



CEWELD OA 60-68B

TYPE Seamless metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.

APPLICATIONS **CEWELD® OA 60-68** is a chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRc.

PROPERTIES The hardfacing with **CEWELD® OA 60-68** contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The hard surfacing contains check cracks, but this does not impair wear resistance. These cracks reduce the stresses in the layer and prevent it from delaminating from the base material.

CLASSIFICATION EN ISO 14700: T Fe13
DIN 8555: MF 4-GF-65-G

SUITABLE FOR Cr-free Hardfacing alloy against extreme abrasion like agricultural equipment, sand, snow scratchers, stone cutting tools and mining equipment, Highway construction equipment and conveyor chains, mixing paddles, cement pumps components, etc. 3 layer hardness : up to 70 HRc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	B
0.5	0.3	1.1	0.3	1.5	1.5	Rem.	4.2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				65 HRc

REDRYING 140°C / 24 hr

HARDNESS HRC first layer: 61-64HRc, second layer 62-68HRc

GAS ACC. EN ISO 14175



CEWELD OA 60-68B

OA 60-68B 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663403674

OA 60-68B 1,6MM

Packaging	KG/unit	EanCode
BS-300	16	8720663403681