



CEWELD OA 54 L

TYPE High-alloyed tubular wire on a C-Cr. carbide basis for abrasive wear resistance in combination with corrosion.

APPLICATIONS CEWELD ® OA 54 L is a high C-Cr alloyed flux-cored wire. It is suitable for applications that are subject to heavy wear from mineral substances and corrosion.
Its main applications are in the following areas: corrosion-resistant kneaders, bushings, pumps, mixer blades, screw conveyors, press screws, oil screws.

PROPERTIES CEWELD ® OA 54 L should be applied in 2-3 layers with a maximum thickness of 8-10 mm.
Crack-free application of the weld metal is possible with appropriate heat management. It should be preheated to approx. 450°C, and the temperature should be maintained during the welding process.
Care should be taken to ensure slow cooling, using oven cooling if necessary.
Cracks in the weld metal can only be avoided with high preheating.

CLASSIFICATION EN ISO 14700: T ZFe14
DIN 8555: MF 10-60-CGT

SUITABLE FOR 56-59 HRc hardfacing alloy, Mixing peddles, Press screws, Kneading machine, screw conveyors, pumps etc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	Fe
3.7	1.2	0.2	32	0.2	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				57 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175



CEWELD OA 54 L

OA 54 L 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720682051849