CEWELD OA 64

certilas® THE FILLER METAL SPECIALIST

TYPE

Fluxcored wire for hardfacing, weldable without protective gas.

APPLICATIONS

Rebuilding wornout parts or protecting new machine parts to increase life that suffer from grinding wear combined with increased temperatures.

PROPERTIES

High C-, Cr-, Mo-, Nb-, V-, W-alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas. Extreme good wear resistance even at higher temperatures up to 650°C. More than 1 or 2 layers should not be deposited. Hardness reduction at 400°C app. 4%, at 650°C app. 10%. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals. If a buffer layer with higher hardness is required, then OA 59H should be used. Equivalent in SMAW: Dur 64

CLASSIFICATION

EN ISO	14700: T Fe16
DIN	8555: MF 10-GF-65-GZ

SUITABLE FOR

For fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, sugar mill hammer and knives, clinker crushers, coal mill rollers, screw conveyors, sintering lines, mixer blades etc.

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	Nb	V	W
5	1.4	0.4	21	6.5	6.5	0.9	2.1

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				64 HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

CEWELD OA 64

OA 64 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403742

OA 64 2,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403759

OA 64 2,4MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403766

OA 64 2,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403773