



CEWELD OA 67 NiB

TYPE	Fluxcored wire for hardfacing with exceptional hardness.				
APPLICATIONS	Hardfacing wire against heavy wear with excellent abrasion resistance against sand and minerals.				
PROPRIÉTÉS	Extreme good wear resistance even with thin coating thickness due to a high amount of Borium carbides. A extreme high hardness is already achieved in the first layer. The weld deposit will show release cracks to offer better bonding strength with the base metal. More than 1 layer should not be deposited. A Buffer layer is recommended in case of sensitive base material or old unknown layers. OA 67 NiBo can be welded without using protective gas (open arc) but is also available as Gas shielded version.				
CLASSIFICATION	EN ISO	14700: T Fe13	DIN	8555: MF 2-GF-70-G	
CONVIENT POUR	Mining and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps, screw conveyors, sintering lines, earth moving equipment etc.				
AGRÉMENTS					
POSITIONS DE SOUDAGE	 PA  PB				
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Ni	B
	0.5	1.2	1.8	2.9	4.8
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	$R_{P0,2}$ (MPa)	R_m (MPa)	A5 (%)	Hardness
	As Welded				67 HRc
ETUVAGE	140°C / 24 hr				

GAS ACC. EN ISO 14175