



CEWELD OA 615

TYPE	Medium -alloyed tubular wire on a C-Cr-Mo-W-V basis for high hardness up to 550°C.								
ANWENDUNGEN	Recommended for parts subject to strong mineral abrasion and erosion.								
EIGENSCHAFTEN	Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas.								
KLASSIFIKATION	EN ISO		14700: T Fe6						
GEEIGNET FÜR	Cement pumps, Crusher bars, Hammer and Blooming table rolls, Mineral and Brick industry.								
ZULASSUNGEN									
SCHWEISSPOSITIONEN	  								
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Mo	V	Fe	W	
	0.55	1	2.7	6.7	1.6	1.5	Rem.	1	
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)		R _m (MPa)		A ₅ (%)		Hardness
	As Welded								60 HRc
RÜCKTROCKNUNG	140°C / 24 hr								
GAS ACC. EN ISO 14175									



CEWELD OA 615

OA 615 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403384

OA 615 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403391