



# CEWELD OA 67 NiB

|              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|--------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE         | Fluxcored wire for hardfacing with exceptional hardness.                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| APPLICATIONS | Hardfacing wire against heavy wear with excelent 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 strenght 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 conveyers, sintering lines, earth moving equipment etc. |
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## AGRÉMENTS

## POSITIONS DE SOUDAGE



## 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 <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      |                         |                      |        | 67 HRc   |

|         |               |
|---------|---------------|
| ETUVAGE | 140°C / 24 hr |
|---------|---------------|

GAS ACC. EN ISO 14175