



# CEWELD OA 550-VW

**TYPE** Medium -alloyed tubular wire on a C-Cr-Mo-W basis for high hardness up to 550°C.

**APPLICATIONS** Recommended for parts subject to strong abrasion and erosion with impact.  
Excavator teeth, excavator cutting edges, gravel pumps, screw conveyors, blow bars, crusher rollers, road construction, shredder plants, Turasse, rock processing, scrap grabs

**PROPERTIES** Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. Too 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 basematerial or old layers. Weldable without protective gas.

**CLASSIFICATION** EN ISO 14700: T Fe6  
DIN 8555: MF 6-60-PT

**SUITABLE FOR** HRc 55-58, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry.

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Si  | Mn  | Cr | Mo  | V   | Fe   | W   |
|------|-----|-----|----|-----|-----|------|-----|
| 0.55 | 0.9 | 2.8 | 7  | 1.6 | 1.8 | Rem. | 0.9 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 55 HRc   |

**REDRYING** 140°C / 24 hr

**GAS ACC.** EN ISO 14175



# CEWELD OA 550-VW

OA 550-VW 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403315 |

OA 550-VW 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403490 |

OA 550-VW 2,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663403414 |