



# CEWELD OA SS 60

**TYPE** High-Mo alloyed flux cored wire on a „High Speed steel basis“ (HSS) for extreme hard deposits on parts subject to strong impact and high pressure, weldable without protective gas.

**APPLICATIONS** Rebuilding wornout parts that faces wear and impact combined with increased working temperatures. (Excellent alloy for making cutting tools out of mild steel)

**PROPERTIES** High wear resistance and similar structure as High speed tool steels. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible basematerial or old Hardface-layers.

**CLASSIFICATION** EN ISO 14700: T Fe4

**SUITABLE FOR** 59-62 HRc hardfacing alloy for cutting edges, wood shredders, knives, recycling equipment, HSS, High speed tool steel alloy. Cutting edges on knives and share blades, pumps, mixer blades, wood shredders etc.. (Excellent alloy for making cutting tools out of mild steel)

**APPROVALS**

**WELDING POSITIONS**



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

C	Mn	Si	Cr	W	Mo	V	Fe
0.8	0.4	0.6	4.5	2	8	1.5	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				59 HRc

**REDRYING** 140°C / 24 hr

**GAS ACC.** EN ISO 14175



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OA SS 60 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403926