



# CEWELD OA 615

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

**APPLICATIONS** Recommended for parts subject to strong mineral abrasion and erosion.

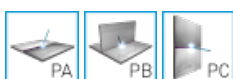
**PROPERTIES** Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. Too much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas.

**CLASSIFICATION** EN ISO 14700: T Fe6

**SUITABLE FOR** 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	1	2.7	6.7	1.6	1.5	Rem.	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				60 HRc

**REDRYING** 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