



# CEWELD OA 68 Nb

**TYPE** High C-, Cr-, Mo, Nb-, V-, alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas.

**APPLICATIONS** Hardfacing wornout parts that requires maximum hardness in just 1 or 2 layers combined with highest wear resistance.

**PROPRIÉTÉS** Extreme good wear resistance even at increased working temperatures. More than 1, maximum 2 layers should not be deposited. A Buffer layer with OA 4370, OA MnCr or ER 100 is recommended.

**CLASSIFICATION** EN ISO 14700: T Fe16  
DIN 8555: MF 10-GF-70-G

**CONVIENT POUR** 67-69 HRc hardfacing alloy, for fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, clinker crushers, stone recycling, screw conveyors, sintering lines, mixer blades, wear plates, earth moving equipment etc.

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



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

C	Si	Mn	Cr	Mo	Nb	V	B
4	1.2	0.25	18	0.3	11	0.45	1.8

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded				69 HRc

**ETUVAGE** 140°C / 24 hr

**GAS ACC. EN ISO 14175**



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OA 68 NB 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403810