CEWELD OA 615

certilas® THE FILLER METAL SPECIALIST

TYPE	Medium -alloyed tubular wire on a C-Cr-Mo-W-V basis for high hardness up to 550°C.
ANWENDUNGEN	Recommended for parts subject to strong mineral abrasion and erosion.
EIGENSCHAFTEN	Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To 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.
KLASSIFIKATION	EN ISO 14700: T Fe6
GEEIGNET FÜR	Cement pumps, Crusher bars, Hammer and Blooming table rolls, Mineral and Brick industry.
ZULASSUNGEN	
SCHWEISSPOSITIONEN	

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	Cr	Mo	V	Fe	W
0.55	1	2.7	6.7	1.6	1.5	Rem.	1

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				60 HRc

RÜCKTROCKNUNG 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