CEWELD®

OA WC2-Fe

CATEGORY	FCAW Flux-Cored
TYPE	Iron based flux cored wire for hardfacing containing a high amount of fused tungsten carbides.
APPLICATIONS	This fused tungsten carbide based alloy provides an excellent resistance against extreme abrasion wear. OA WC2-Fe can be applied on most type of steels except on cast iron or Mn-steel. This alloy is the most wear resistant type in almost any hardfacing application.
PROPERTIES	2400 HV Iron and Tungsten based hardfacing alloy containing 52-58% (depending on wire diameter) tungsten carbides. OA WC2-Fe has good welding characteristics. Multi-layer deposits are not recommended due to the extreme high hardness. Fused tungsten carbide will guaranty a long life for several wear applications. Best to be used without gas protection (self shielded).
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe 20-65-GZ DIN 8555: MF-21-65-GZ
SUITABLE FOR	Rebuilding of stabilisers and other oilfield tools where maximum protection against abrasion is required. Also for augers, impellers, mixer plates in the brick and clay industry and on decanter screws or hardfacing deep drilling equipment.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL ANALYSIS %

Fused tungsten carbides	Fe
52-58%	Bal.

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	Impact Energy (J) ISO-V -40°C	Hardness matrix HRc	Hardness Carbides HV0.4
AW						65-67	2400

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spooling type	kg / spools
1.6	22-28	120-200	K-300 / B-415	15 / 22
2.4	24-29	160-290	K-300 / B-415	15 / 22

REDRYING TEMPERATURE	150°C / 24hr (normaly not required)