CEWELD®

# OA 56Nb

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| CATEGORY | FCAW Flux-Cored |
| TYPE | High-alloyed tubular wire on a C-Cr-Nb-W-V carbide basis against schock and abrasion. |
| APPLICATIONS | Rebuilding and hardfacing wornout parts that faces heavy shock and abrasion at the same time. |
| PROPERTIES | Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the first layer thank to the Nb carbides. The choice for the buffer layer is depending on the base metal and not always necessary. |
| CLASSIFICATION | AWS A 5.21:<br>EN ISO 14700: T Fe8<br>DIN 8555: MF 6-55-GP |
| SUITABLE FOR | 55-57 HRc hardfacing alloy against shocks and mineral wear, Cement rollers and crushers, Mineral and brick crushing industry, Screw conveyers, carbidge recycling etc. |
| APPROVALS | CE approved |
| WELDING POSITIONS: |  |



## WELD METAL ANALYSIS %

| C | Mn | Si | Cr | Nb | V | W |
|---|---|---|---|---|---|---|
| 1.40 | .1.30 | 0.70 | 6.50 | 8.0 | 1.0 | 1.2 |

## MECHANICAL PROPERTIES

| Heat Treatment | $R_{P0,2}$ (N/mm$^2$) | Rm (N/mm$^2$) | A5 (%) | Impact Energy (J) ISO-V -20°C | -40°C | -60°C | Hardness HRc / HV |
|---|---|---|---|---|---|---|---|
| AW | | | | | | | 55-57 HRc |

AW: as welded

## WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | |
|---|---|---|---|---|
| D (mm) | Voltage (V) | Current (A) | spooling type | kg / spool / drum |
| 1.2 | 18-24 | 100-220 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 1.6 | 20-26 | 160-260 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.0 | 22-26 | 240-280 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.4 | 24-27 | 280-340 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.8 | 25-28 | 320-400 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |

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| REDRYING TEMPERATURE | 150°C / 24hr. |
| STICK OUT | 25-40 mm |