CEWELD®

OA 58

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed fluxcored wire on a C-Cr Carbide basis for extreme wear resistant deposits on Parts subject to strong mineral abrasion.
APPLICATIONS	Rebuilding and or protecting parts that faces extreme abrasion with medium impact and wear plate production.
PROPERTIES	High wear resistance and austenitic structure deposits. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old hardface-layers. Weldable without protective gas.
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe14 DIN 8555: MF 10-60-G
SUITABLE FOR	Cement industry, pumps, mixer blades, earthmoving equipment, dredging equipment and parts, wear plates, crushing equipment, blast furnace parts etc...
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo
5	0.7	1.1	27	1.5

MECHANICAL PROPERTIES

Delution results	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc
First layer on mild steel							50-57
Third layer on mild steel							57-59

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltge (V)	Current (A)	spool type	kg / spool
1.6	20-30	180-320	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.0	24-32	200-340	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.4	26-34	260-370	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.8	28-34	320-450	S-300 / Coil B-450 / Drum	15 / 25 / 300

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