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	EN ISO 14700: T Fe20 DIN 8555: MF 21-GF-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	No Approvals Found

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

WSC
56

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Vickers
As Welded /					Avg. 2400

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	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 140°C / 24 hr

GAS ACCORDING EN 14175