



CEWELD AA 66B

TYPE	High alloyed fluxcored wire for hardfacing against extreme abrasion.					
ANWENDUNGEN	Rebuilding wornout parts or protecting new machine parts to increase life that suffer from extreme abrasive wear					
EIGENSCHAFTEN	High C-Cr-Nb, B-alloyed flux-cored wire electrode which forms extremely hard complex carbides for extremely wear resistant deposits on parts subject to excessively heavy abrasive wear weldable under mixed gas. Extreme good wear resistance due to excelent first layer hardness properties. More than 1 or 2 layers should not be deposited. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals..					
KLASSIFIKATION	EN ISO	14700: T Fe16				
GEEIGNET FÜR	64-68 HRc Hardfacing wire used in mining, agriculture and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps with excelent abrasion and wear resistance against sand and minerals					
ZULASSUNGEN						
SCHWEISSPOSITIONEN	 PA  PB  PC					
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Ni	Nb	B
	2.5	0.6	2	11.5	5	2
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded				66 HRc	
RÜCKTROCKNUNG	Not required					
GAS ACC. EN ISO 14175	M21					