



CEWELD OA 63 VWB

TYPE High-alloyed tubular wire on a C-Cr-V-W-B carbide basis for extreme hard deposits on parts subject to strong mineral abrasion, weldable without protective gas.

APPLICATIONS Hardfacing and rebuilding parts that faces severe aggressive abrasion in cement industry, mining and stone crushing.

PROPERTIES Extreme abrasion resistant with improved impact properties when combined with OA 400 as buffer layer. Due to the combination Cr-V-W-B carbides the deposit structure contains very fine particles that results in excellent wear resistance against heavy abrasion. Usually the maximum number of layers is 2 till 3 but when using a special stringer build up technick with release cracks, upto 15 layers is possible.

CLASSIFICATION EN ISO 14700: T Fe15
DIN 8555: MF 10-GF-65-G

SUITABLE FOR Nihard IV segmented roller and parts without buffer layer, slurry pumps, loaders, sand and earth moving equipment such as buckets and teeth, dredge buckets, crushing equipment, rockwool rolls and brick industry, cement rollers, table segments, wear plates etc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	V	W	B
5	1.1	0.8	25	6	2	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				63 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175