
# CEWELD OA 615

certilas® THE FILLER METAL SPECIALIST

| | |
|---|---|
| TYPE | Medium -alloyed tubular wire on a C-Cr-Mo-W-V basis for high hardness up to 550°C. |
| APPLICATIONS | Recommended for parts subject to strong mineral abrasion and erosion. |
| PROPRIÉTÉS | Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas. |
| CLASSIFICATION | EN ISO 14700: T Fe6 |
| CONVIENT POUR | Cement pumps, Crusher bars, Hammer and Blooming table rolls, Mineral and Brick industry. |
| AGRÉMENTS | |
| POSITIONS DE SOUDAGE |   |

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Mo | V | Fe | W |
|---|---|---|---|---|---|---|---|
| 0.55 | 1 | 2.7 | 6.7 | 1.6 | 1.5 | Rem. | 1 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Hardness |
|---|---|---|---|---|
| As Welded | | | | 60 HRc |

ETUVAGE 140°C / 24 hr

GAS ACC. EN ISO 14175




# CEWELD OA 615

OA 615 1,2MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| BS-300 | 15 | 8720663403384 |

OA 615 1,6MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| BS-300 | 15 | 8720663403391 |