



# CEWELD AA 66B

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |        |          |   |
|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------|----------|---|
| TYPE                                        | High alloyed fluxcored wire for hardfacing against extreme abrasion.                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |        |          |   |
| APPLICATIONS                                | Rebuilding wornout parts or protecting new machine parts to increase life that suffer from extreme abrasive wear                                                                                                                                                                                                                                                                                                                                       |                         |                      |        |          |   |
| PROPERTIES                                  | 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.. |                         |                      |        |          |   |
| CLASSIFICATION                              | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         | 14700: T Fe16        |        |          |   |
| SUITABLE FOR                                | 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                                                                                                                                                                                                                            |                         |                      |        |          |   |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |        |          |   |
| WELDING POSITIONS                           | <div> PA</div> <div> PB</div> <div> PC</div>                                                                                                                                                        |                         |                      |        |          |   |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                      | Mn                   | Ni     | Nb       | B |
|                                             | 2.5                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 0.6                     | 2                    | 11.5   | 5        | 2 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |   |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |        | 66 HRc   |   |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |        |          |   |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |        |          |   |