

OA 55 TC

CATEGORY	FCAW Flux-Cored
TYPE	Titanium -alloyed tubular wire on a C-Cr-Ti carbide basis for hardfacing.
APPLICATIONS	Rebuilding and or protecting wear parts that faces severe impact combined with heavy abrasion.
PROPERTIES	Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the second layer thanks to the Titanium carbides. The choice for the buffer layer is depending on the base metal and not always necessary.

CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe8 DIN 8555: MF 6-60-GP
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SUITABLE FOR	HRc 54-56, hardfacing alloy for Cement crusher rollers, Mineral and brick industry, Hammers, Screw conveyers, gravel pumps, bucket collars, dredger teeth etc.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %						
C	Mn	Si	Cr	Ti	Mo	
1.8	1.45	1.6	5-7	4.5	1-1.5	

MECHANICAL PROPERTIES							
Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							54-59

AW: as welded

WELDING PARAMETERS / PACKING					
Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum	kg / pallet
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600

REDRYING TEMPERATURE	150°C / 24hr.
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STICK OUT	25-40 mm
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