

OA 59

CATEGORY FCAW Flux-Cored

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

APPLICATIONS Cladding and rebuilding parts that are subject to severe abrasion.

PROPERTIES Extreme abrasion resistant with reasonable impact properties and temperature resistance up to 300°C. Due to the combination Cr and Nb 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 also possible.

CLASSIFICATION

AWS	A 5.21
EN ISO	14700: T Fe15
DIN	8555: MF 10-60-G

SUITABLE FOR Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, rockwool rolls and brick industry, cement rollers, tables, Nihard and Mohard parts without buffer layer, slurry pumps, loaders, wear plates etc.
Equivalent in SMAW: [Dur 62S](#), [Dur 63Nb](#)

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Nb	Specials
5.00	0.50	1.00	22.00	7.00	+

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							62-65

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	24-28	150-350	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.0	26-30	200-400	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.4	26-30	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.8	28-32	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330

REDRYING TEMPERATURE 150°C / 24hr (normaly not needed)

GAS ACCORDING EN 14175: not required