

## OA 60 Mo

**CATEGORY** FCAW Flux-Cored

**TYPE** High-alloyed fluxcored wire on a C-Cr-Mo Carbide basis for extreme wear resistant deposits on Parts subject to strong mineral abrasion.

**APPLICATIONS** Rebuilding and or protecting parts that faces extreme abrasion with medium impact.

**PROPERTIES** High wear resistance and austenitic structure deposits. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old hardface-layers. Weldable without protective gas.

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: T Fe14
DIN	8555: MF 10-60-CGT

**SUITABLE FOR** Cement industry, pumps, mixer blades, earthmoving equipment, dredging equipment and parts, wear plates, crushing equipment, blast furnace parts etc...

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Mo
3.7	0.20	0.9-1.2	28-33	0.6

**MECHANICAL PROPERTIES**

Delution results	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
First layer on mild steel							48-55
Third layer on mild steel							58-60

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	22-35	160-340	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.0	24-35	180-400	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.4	26-35	240-460	S-300 / Coil B-450 / Drum	15 / 25 / 300
2.8	28-35	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 300

**REDRYING TEMPERATURE** 150°C / 24hr

**STICK OUT** 25-40 mm