

OA 600

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-Mo carbide basis against shock and abrasion.
APPLICATIONS	Rebuilding and hardfacing wornout parts that faces heavy shock and abrasion at the same time.
PROPERTIES	Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the first layer. 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 Fe4
	DIN	8555: MF 6-55-GP

SUITABLE FOR	55-57 HRc hardfacing alloy against shocks and mineral wear, rollers and crushers, Mineral and brick crushing industry, Screw conveyers, carbidge recycling 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	Mo	W
0,5	3	0.9	6.50	0,7	0,4

MECHANICAL PROPERTIES							
Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW							55-57 HRc

AW: as welded

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum
1.2	18-24	100-220	S-300 / Coil B-450 / Drum	15 / 30 / 300
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	25-28	320-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

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