

OA 615

CATEGORY FCAW Flux-Cored

TYPE High alloyed fluxcored wire without slag for hardfacing using protective gas M12/M21 or without gas.

APPLICATIONS Rebuilding wornout parts that requires good resistance against wear and impact

PROPERTIES Due to the several complex carbides this alloy offers very good resistance against high impact stress in combination with abrasion by metal to metal wear and heat influence, all weld metal requires no buffer layer except on materials considered critical or old hardfacing layers. In this Situation OA 4370, ER 100 S-G or OA MnCr is recommended. Suited for wear parts subject to medium impact and shock.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe4
DIN	8555: MF 6-60-PT

SUITABLE FOR 58 HRc hardfacing alloy for Bucket teeth, conveyors, crushers, mixer blades, cement rollers, mixers, loaders, mining, earthmoving equipment, carbidge recycling paddles etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	V	Mo	W	Fe
0.5	3.0	1.0	6.5	1.5	1.5	1.1	rem

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							57-59

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum
1.2	18-26	100-240	K-300 / Drums	15 / 250
1.6	20-28	160-275	K-300 / Drums	15 / 250

REDRYING TEMPERATURE 150°C / 24hr.

NOTE Other spool types and dimensions are also available