

## OA 59H

**CATEGORY** FCAW Flux-Cored

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

**APPLICATIONS** Rebuilding and hardfacing wornout parts that faces extreme abrasion with low impact properties.

**PROPERTIES** Extreme abrasion resistance against sand and minerals with fair impact properties and temperature resistance up to 450°C.

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: T Fe15
DIN	8555: MF 10-65-G

**SUITABLE FOR** 64-66 HRc hardfacing alloy for Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, wear plates, rockwool rolls and brick industry

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Nb	B
5.3	0.40	1.3	22.00	7.00	+

**MECHANICAL PROPERTIES**

Heat Treatment	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	
AW							62-65

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	22-26	150-280	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.0	22-28	200-280	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.4	26-29	260-320	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.8	27-30	320-380	S-300 / Coil B-450 / Drum	15 / 25 / 250-300

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACCORDING EN 14175:** not required