

OA 63

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.

APPLICATIONS Rebuilding and or protecting wear parts that faces extreme abrasion and medium to low impact.

PROPERTIES Extreme wear resistance even at higher temperatures. The deposit gives already a High hardness in the first layer. A buffer layer is recommended in case of sensible base material or old layers. Weldable without protective gas

CLASSIFICATION

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

SUITABLE FOR 63-67 HRc hardfacing alloy ,Fan blades, Bucket lips, Mining, Cement, Mineral hammers, coke wear plates etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Nb	Si	Cr	B
5.4	7	0.8	22	+

ALL WELD METAL 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 / 66

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
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
3.2	26-30	360-450	S-300 / Coil B-450 / Drum	15 / 30 / 300

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm