

## OA 63V

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-V carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.
APPLICATIONS	Rebuilding and or protecting wear parts that faces severe abrasion and stress attack.
PROPERTIES	Extreme abrasion resistant combined with stress and medium impact. Eeldable without protective gas.
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe16 DIN 8555: MF 10-GF-65-CGRS
SUITABLE FOR	64-67 HRc hardfacing alloy for Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, stone crushers and brick industry
APPROVALS	CE approved

### WELDING POSITIONS:



### WELD METAL ANALYSIS %

C	V	Si	Cr
5.00	10.00	1.00	22.00

### ALL WELD METAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							64-67

AW: as welded

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6	24-28	150-350	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.0	26-30	200-400	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.4	26-30	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.8	28-32	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm