

## OA 64

**CATEGORY** FCAW Flux-Cored

**TYPE** Fluxcored wire for hardfacing, weldable without protective gas.

**APPLICATIONS** Rebuilding wornout parts or protecting new machine parts to increase life that suffer from grinding wear combined with increased temperatures.

**PROPERTIES** High C-, Cr-, Mo-, Nb-, V-, W-alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas. Extreme good wear resistance even at higher temperatures up to 650°C. More than 1 or 2 layers should not be deposited. Hardness reduction at 400°C app. 4%, at 650°C app. 10%. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals..  
Equivalent in SMAW: [Dur 64](#)

**CLASSIFICATION** AWS A 5.21:  
EN ISO 14700: T Fe16  
DIN 8555: MF-10-65-GZ

**SUITABLE FOR** For fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, sugar mill hammer and knives, clinker crushers, coal mill rollers, screw conveyors, sintering lines, mixer blades etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Mo	Nb	V	W	Fe
5.20	0.4	1.0	21.0	7.0	7.0	1.0	2.0	bal

**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							63-65

AW: as welded

**WELDING PARAMETERS / PACKING**

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

**REDRYING TEMPERATURE** 150°C / 24hr