

OA 67 NiBo

CATEGORY FCAW Flux-Cored

TYPE Fluxcored wire for hardfacing with exceptional hardness.

APPLICATIONS Hardfacing wire against heavy wear with excellent abrasion resistance against sand and minerals.

PROPERTIES Extreme good wear resistance even with thin coating thickness due to a high amount of Borium carbides. A extreme high hardness is already achieved in the first layer. The weld deposit will show release cracks to offer better bonding strength with the base metal. More than 1 layer should not be deposited. A Buffer layer is recommended in case of sensitive base material or old unknown layers. OA 67 NiBo can be welded without using protective gas (open arc)

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe13
DIN	8555: MF 2 - GF - 65 G

SUITABLE FOR Mining and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps, screw conveyers, sintering lines, earth moving equipment etc.

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	V	B
0,5	1,5	1,2	-	3	-	+	4,8

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							65-68

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,6	24-28	150-350	K-300 / K-415 / Drum	15 / 25 / 300	
2,0	26-30	200-400	K-300 / K-415 / Drum	15 / 25 / 300	
2,4	26-30	250-450	K-415 / Drum	25 / 300	
2,8	28-32	250-450	K-415 / Drum	25 / 300	

REDRYING TEMPERATURE 150°C / 24hr.

STICK OUT Between 25 and 40 mm