

OA 60-70B

CATEGORY FCAW Flux-Cored

TYPE High alloyed seamless metal cored wire for hardfacing against extreme abrasion.

APPLICATIONS Rebuilding wornout parts or protecting new machine parts to increase life that suffer from extreme abrasive wear

PROPERTIES High C-, Cr-, B-alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable with and without protective gas. Extreme good wear resistance due to excellent first layer hardness properties. More than 1 or 2 layers should not be deposited. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals..

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Z Fe13
DIN	8555: MF 10 GF - 70 G

SUITABLE FOR 60-70 HRc Hardfacing wire used in mining, agriculture and steel mills, conveyor chains, agriculture, construction, mixer blades, paddles, cement pumps with excellent abrasion and wear resistance against sand and minerals

APPROVALS CE approved

WELDING POSITIONS:



PURE WELD DEPOSIT

C	Mn	Si	Cr	B
1.8	0.8	0.6	8.2	4.2

MECHANICAL PROPERTIES

number of layers	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
1 layer							60-64
2 layers							65-70

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.6	14-30	120-300	K-300	16	1024

REDRYING TEMPERATURE not required

GAS ACC. EN ISO: 14175 M21 or without gas