

AA 66B

CATEGORY FCAW Flux-Cored

TYPE High alloyed fluxcored 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-Nb, B-alloyed flux-cored wire electrode which forms extremely hard complex carbides for extremely wear resistant deposits on parts subject to excessively heavy abrasive wear weldable under mixed 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 Fe16
DIN	8555: MF 10 GF - 70 G

SUITABLE FOR 64-68 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	Nb	B
2.5	2.0	0.6	11.5	5.0	2.2

MECHANICAL PROPERTIES

Condition as welded	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	
Pure weld deposit							64-68

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	18-26	120-270	K-300	15	1080	
1.6	20-26	140-280	K-300	15	1080	

REDRYING TEMPERATURE not required

GAS ACC. EN ISO: 14175 M21