

OA 4028

CATEGORY FCAW Flux-Cored

TYPE Fluxcored welding wire for corrosion resistant hardfacing applications

APPLICATIONS Rebuilding parts that faces wear combined with corrosion and impact.

PROPERTIES Extreme tough and corrosion resistant weld deposit, well suited for parts that encounter wear from sea water plant and power plant operation. This acid corrosion resistance alloy has a 14% Cr. content combined with 0,3% carbon that results in excellent wear properties.

CLASSIFICATION

AWS	5.22: ~E420
EN ISO	14700: T Z Fe8
DIN: W.Nr.	1.4028

SUITABLE FOR Bridge bearings, sealing surfaces, corrosion slide ring sealing, roller bearings, centrifuges, valves, pumps, shafts etc.

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo
0.30	0.80	0.60	14.0	0.40	-

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							46-48

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / Drum	kg / pallet
1.2	20-24	150-200	K-300 / K-415 / Drum	15 / 25 / 300	
1.6	22-26	180-240	K-300 / K-415 / Drum	15 / 25 / 300	
2.0	25-27	220-260	K-415 / Drum	25 / 300	
2.4	25-27	260-300	K-415 / Drum	25 / 300	

REDRYING TEMPERATURE 150°C / 24hr

TYPES available as: OA = open arc, G = gas shielded, SA = submerged arc