

## OA 54 L

**CATEGORY** FCAW Flux-Cored

**TYPE** High-alloyed tubular wire on a C-Cr. carbide basis for abrasive wear resistance in combination with corrosion.

**APPLICATIONS** Rebuilding and or protecting wear parts against extreme abrasion in combination with corrosion, with low impact.

**PROPERTIES** Can be welded crack free by preheating approximately 450°C and keep that also as interpass temperature. Slowly cooling down, for example in an oven.

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: ~T Fe14-60-CGT
DIN	8555: MF 10-60-CGT

**SUITABLE FOR** 56-59 HRc hardfacing alloy, Mixing peddles, Press screws, Kneading machine, screw conveyors, pumps etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



### WELD METAL ANALYSIS %

C	Si	Mn	Cr	Fe
3.7	1.2	0.2	32	Rem

### ALL WELD METAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							56-59

AW: as welded 3 layers

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6	20-27	120-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-27	140-320	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	22-29	160-380	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	22-30	180-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

**REDRYING TEMPERATURE** 150°C / 24hr

**STICK OUT** 25-40 mm