

OA 57

CATEGORY FCAW Flux-Cored

TYPE High-alloyed tubular wire on a C-Cr. carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.

APPLICATIONS Rebuilding and or protecting wear parts against extreme abrasion with low impact.

PROPERTIES High C-, Cr- alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas. More than 3 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.. Equivalent in SMAW: [Dur 62S](#)

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: ~T Fe15-65-GC
DIN	8555: MF 10-65-GR

SUITABLE FOR 60-64 HRc hardfacing alloy, Cement, Mineral mixing peddles, coke wear plates, Fan blades, screw conveyors, pumps etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Si	Mn	Cr	Fe
5.5	1.0	0.1	32	Rem

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							60-64

AW: as welded 3 layers

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	20-27	160-280	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-28	240-300	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	24-28	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	26-29	300-380	S-300 / Coil B-450 / Drum	15 / 30 / 300

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm