

OA 57-62 Nb

CATEGORY FCAW Flux-Cored

TYPE High alloyed seamless fluxcored wire without slag for hardfacing.

APPLICATIONS OA 57-62 Nb is designed for multiple layer welding and offers excellent resistance against combinations of wear and shock.

PROPERTIES Due to the high Niobium content this alloy offers very good resistance against abrasion by minerals, all weld metal requires no buffer layer except on materials considered critical or old hardsurfacing layers. In this Situation [OA 4370](#), [ER 100 SG](#) is recommended. Suited for wear parts subject to heavy impact and shock. In critical cases such as cement rollers the interpass temperature should be kept at 270°C for the best results. The weld metal is only machinable by grinding. Due to the production method (seamless wire) this wire can be stored for a long time without the risk of moisture pick up and has excellent feeding and welding properties. Weldable without protective gas. (Also weldable with M21 mixed gas)

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe8
DIN	8555: MF 6-55-GP

SUITABLE FOR Hardfacing alloy against heavy impact and shock for hammers, crushers, buckets, conveyors, crusher jaws, stone crushers, crushing rollers etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Nb
1.30	0.90	1.0	6.50	6.50

MECHANICAL 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							57-62

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage	Current (A) (DC+)	spool type	kg / spool	kg / pallet
1.2	22-32	150-260	K 300 / drums	16 / 300	1024 / 600
1.6	24-34	200-330	K-300 / K 415 / drums	16 / 25 / 300	1024 / 1000 / 600
2,4	26-34	250-420	K-300 / K 415 / drums	16 / 25 / 300	1024 / 1000 / 600

REDRYING TEMPERATURE not required