

OA 58

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| CATEGORY | FCAW Flux-Cored |
| TYPE | High-alloyed fluxcored wire on a C-Cr Carbide basis for extreme wear resistant deposits on Parts subject to strong mineral abrasion. |
| APPLICATIONS | Rebuilding and or protecting parts that faces extreme abrasion with medium impact and wear plate production. |
| PROPERTIES | High wear resistance and austenitic structure deposits. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old hardface-layers. Weldable without protective gas. |
| CLASSIFICATION | AWS A 5.21: EN ISO 14700: T Fe14 DIN 8555: MF 10-60-G |
| SUITABLE FOR | Cement industry, pumps, mixer blades, earthmoving equipment, dredging equipment and parts, wear plates, crushing equipment, blast furnace parts etc... |
| APPROVALS | CE approved |

WELDING POSITIONS:



WELD METAL ANALYSIS %

| | | | | |
|---|-----|-----|----|-----|
| C | Mn | Si | Cr | Mo |
| 5 | 0.7 | 1.1 | 27 | 1.5 |

MECHANICAL PROPERTIES

| Delution results | 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 | |
| First layer on mild steel | | | | | | | 50-57 |
| Third layer on mild steel | | | | | | | 57-59 |

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | |
|--------------------|-------------|-------------|---------------------------|---------------|
| D (mm) | Voltage (V) | Current (A) | spool type | kg / spool |
| 1.6 | 20-30 | 180-320 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.0 | 24-32 | 200-340 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.4 | 26-34 | 260-370 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.8 | 28-34 | 320-450 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm