

OA 59 H

CATEGORY FCAW Flux-Cored

TYPE High-alloyed tubular wire on a C-Cr-Nb-B carbide basis for extreme hard deposits on parts subject to strong mineral abrasion, weldable without protective gas.

APPLICATIONS Rebuilding and hardfacing wornout parts that faces extreme abrasion with low impact properties.

PROPERTIES Extreme abrasion resistance against sand and minerals with fair impact properties and temperature resistance up to 450°C.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe15
DIN	8555: MF 10-65-G

SUITABLE FOR 64-66 HRc hardfacing alloy for Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, wear plates, rockwool rolls and brick industry

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Nb	B
5.3	0.40	1.3	22.00	7.00	+

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							62-65

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	22-26	150-280	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.0	22-28	200-280	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.4	26-29	260-320	S-300 / Coil B-450 / Drum	15 / 25 / 250-300
2.8	27-30	320-380	S-300 / Coil B-450 / Drum	15 / 25 / 250-300

REDRYING TEMPERATURE 150°C / 24hr

GAS ACCORDING EN 14175: not required