

OA 60 Mo

CATEGORY FCAW Flux-Cored

TYPE High-alloyed fluxcored wire on a C-Cr-Mo 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.

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-CGT |

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 |
| 3.7 | 0.20 | 0.9-1.2 | 28-33 | 0.6 |

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 | | | | | | | 48-55 |
| Third layer on mild steel | | | | | | | 58-60 |

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | |
|--------------------|-------------|-------------|---------------------------|---------------|
| D (mm) | Voltage (V) | Current (A) | spool type | kg / spool |
| 1.6 | 22-35 | 160-340 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.0 | 24-35 | 180-400 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.4 | 26-35 | 240-460 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |
| 2.8 | 28-35 | 250-450 | S-300 / Coil B-450 / Drum | 15 / 25 / 300 |

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm