

OA 60-68B

CATEGORY FCAW Flux-Cored

TYPE High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.

APPLICATIONS Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRC.

PROPERTIES The hardfacing contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The hard surfacing contains check cracks, but this does not impair wear resistance.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe13
DIN	8555: MSG 10-GF-65-G

SUITABLE FOR Cr-free Hardfacing alloy against extreme abrasion like agricultural equipment, sand, snow scrapers, stone cutting tools and mining equipment, Highway construction equipment and conveyor chains, mixing paddles, cement pumps components, etc. 2 layer hardness : 61-68HRC.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL VALUES FOR M21 GAS)

C	Mn	Si	Cr	B	Ni
0.50	1.1	0.3	0.3	4.8	1.5

MECHANICAL PROPERTIES

number of layers	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	
1 layer							61-64
2 layer							62-68

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool	kg / pallet
1.2	14-28	80-200	K-300	16	1024
1.6	19-32	100-350	K 300	16	1024

REDRYING TEMPERATURE not required

GAS ACC. ISO 14571: M21 or without gas