

OA 600

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| CATEGORY | FCAW Flux-Cored |
| TYPE | High-alloyed tubular wire on a C-Cr-Mo carbide basis against shock and abrasion. |
| APPLICATIONS | Rebuilding and hardfacing wornout parts that faces heavy shock and abrasion at the same time. |
| PROPERTIES | Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the first layer. The choice for the buffer layer is depending on the base metal and not always necessary. |

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| CLASSIFICATION | AWS | A 5.21: |
| | EN ISO | 14700: T Fe4 |
| | DIN | 8555: MF 6-55-GP |

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| SUITABLE FOR | 55-57 HRc hardfacing alloy against shocks and mineral wear, rollers and crushers, Mineral and brick crushing industry, Screw conveyers, carbidge recycling etc. |
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| APPROVALS | CE approved |
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| WELDING POSITIONS: | |
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| WELD METAL ANALYSIS % | | | | | |
| C | Mn | Si | Cr | Mo | W |
| 0,5 | 3 | 0.9 | 6.50 | 0,7 | 0,4 |

| MECHANICAL PROPERTIES | | | | | | | |
|------------------------------|---|--|-----------------------|-------------------------|-------|-------|----------------------|
| Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness HRc / HV |
| | | | | -20°C | -40°C | -60°C | |
| AW | | | | | | | 55-57 HRc |

AW: as welded

| WELDING PARAMETERS / PACKING | | | | |
|-------------------------------------|-------------|-------------|---------------------------|-------------------|
| Welding Parameters | | | Packing | |
| D (mm) | Voltage (V) | Current (A) | spooling type | kg / spool / drum |
| 1.2 | 18-24 | 100-220 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 1.6 | 20-26 | 160-260 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.0 | 22-26 | 240-280 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.4 | 24-27 | 280-340 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |
| 2.8 | 25-28 | 320-400 | S-300 / Coil B-450 / Drum | 15 / 30 / 300 |

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| REDRYING TEMPERATURE | 150°C / 24hr. |
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| STICK OUT | 25-40 mm |
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