

## OA 612

<b>CATEGORY</b>	FCAW Flux-Cored					
<b>TYPE</b>	High alloyed fluxcored wire for hardfacing.					
<b>APPLICATIONS</b>	Bucket teeth, conveyors, cruscher hammers, coal mine cutters, mixer blades, mixer blades etc.					
<b>PROPERTIES</b>	<p>This alloy offers very good resistance against general abrasion and heavy shock, all weld metal requires no buffer layer except on materials considered critical or in case of old hardfacing layers. In this Situation OA 4370, ER 100 S1 or OA MnCr is recommended.</p> <p>Suited for wear parts subject to strong impact, abrasion and shock. In critical cases the interpass temperature should be kept at 270°C for the best results. The weld metal is only machinable by grinding. Weldable without gas (open arc). (Also weldable under M21 mixed gas)</p>					
<b>CLASSIFICATION</b>	AWS	A 5.21:				
	EN ISO	14700: T Fe8				
	DIN	8555: MF 6-55-RP				
<b>SUITABLE FOR</b>	54 HRC hardfacing alloy for wear resistant overlays, sand pumps, valve seats, dredger equipment, bucket teeth, stone crushing, hammers etc.					
<b>APPROVALS</b>	CE approved					
<b>WELDING POSITIONS:</b>						
<b>WELD METAL ANALYSIS %</b>	C	Mn	Si	Cr	Fe	
	0.5	1.2	0.9	12.5	rem	
<b>ALL WELD METAL PROPERTIES</b>	Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V	Hardness HRC / HV
	AW				-20°C    -40°C    -60°C	54-56
AW: as welded						
<b>WELDING PARAMETERS PACKING</b>	Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum		
1.6	24-34	160-330	S-300 / Drum	15 / 250		
<b>REDRYING TEMPERATURE</b>	150°C / 24hr					
<b>STICK OUT</b>	25-40 mm					