

OA 62

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-B carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.

APPLICATIONS	Rebuilding and or protecting wear parts against extreme abrasion with low impact.
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PROPERTIES	Extreme wear resistance even at higher temperatures. The deposit gives already a High hardness in the first layer. A buffer layer is recommended in case of sensible base material or old layers. Weldable without protective gas. Corresponding electrode: Dur 62 S
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CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe15 DIN 8555: MF 10-70-CGZ
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SUITABLE FOR	64-68 HRc hardfacing alloy, Cement, Mineral mixing, hammers, coke wear plates etc.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %	C	B	Si	Cr
	5.0	2.0	0.8	38

ALL WELD METAL PROPERTIES	Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	Hardness HRc / HV
	AW				-20°C -40°C -60°C	66-68

AW: as welded

WELDING PARAMETERS / PACKING	Welding Parameters		Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.6	24-33	150-320	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	26-33	180-370	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	26-33	220-420	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	28-34	220-420	S-300 / Coil B-450 / Drum	15 / 30 / 300

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