

OA 63

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

APPLICATIONS	Rebuilding and or protecting wear parts that faces extreme abrasion and medium to 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
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CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe15 DIN 8555: MF 10-65--G
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SUITABLE FOR	63-67 HRc hardfacing alloy ,Fan blades, Bucket lips, Mining, Cement, Mineral 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	Nb	Si	Cr	B
	5.4	7	0.8	22	+

ALL WELD METAL PROPERTIES	Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	Hardness HRC
	AW				-20°C -40°C -60°C	62 / 66

AW: as welded

WELDING PARAMETERS / PACKING	Welding Parameters		Packing		
	D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
	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
	3.2	26-30	360-450	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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