

OA 63 V

CATEGORY FCAW Flux-Cored

TYPE High-alloyed tubular wire on a C-Cr-V carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.

APPLICATIONS Rebuilding and or protecting wear parts that faces severe abrasion and stress attack.

PROPERTIES Extreme abrasion resistant combined with stress and medium impact. Eeldable without protective gas.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe16
DIN	8555: MF 10-GF-65-CGRS

SUITABLE FOR 64-67 HRc hardfacing alloy for Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, stone crushers and brick industry

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	V	Si	Cr
5.00	10.00	1.00	22.00

ALL WELD METAL PROPERTIES

Heat Treatment	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	
AW							64-67

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6	24-28	150-350	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.0	26-30	200-400	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.4	26-30	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330
2.8	28-32	250-450	S-300 / Coil B-450 / Drum	15 / 25 / 330

REDRYING TEMPERATURE 150°C / 24hr

STICK OUT 25-40 mm