

OA 63 VWB

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-V-W-B carbide basis for extreme hard deposits on parts subject to strong mineral abrasion, weldable without protective gas.

APPLICATIONS	Hardfacing and rebuilding parts that faces severe aggressive abrasion in cement industry, mining and stone crushing.
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PROPERTIES	Extreme abrasion resistant with improved impact properties when combined with OA 400 as buffer layer. Due to the combination Cr-V-W-B carbides the deposit structure contains very fine particles that results in excellent wear resistance against heavy abrasion. Usually the maximum number of layers is 2 till 3 but when using a special stringer build up technick with release cracks, upto 15 layers is possible.
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CLASSIFICATION	AWS	A 5.21: special alloy
	EN ISO	14700: special alloy
	DIN	8555: MF 10-65-G

SUITABLE FOR	Nihard IV segmented roller and parts without buffer layer, slurry pumps, loaders, sand and earth moving equipment such as buckets and teeth, dredge buckets, crushing equipment, rockwool rolls and brick industry, cement rollers, table segments, wear plates etc.
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APPROVALS	CE approved
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WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	V	W	B	Fe
4.5-6.0	0.7-0.9	1.1-1.3	23-26	4.0-7.0	1.0-3.0	+	Rest

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							62-64

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
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 (normaly not needed)
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