CEWELD®

OA 64

CATEGORY	FCAW Flux-Cored
TYPE	Fluxcored wire for hardfacing, weldable without protective gas.
APPLICATIONS	Rebuilding wornout parts or protecting new machine parts to increase life that suffer from grinding wear combined with increased temperatures.
PROPERTIES	High C-, Cr-, Mo-, Nb-, V-, W-alloyed flux-cored wire electrode which forms extremely hard carbides for extremely hard deposits on parts subject to excessively heavy abrasive wear weldable without protective gas. Extreme good wear resistance even at higher temperatures up to 650ºC. More than 1 or 2 layers should not be deposited. Hardness reduction at 400°C app. 4%, at 650°C app. 10%. A Buffer layer with OA 4370 or OA MnCr is recommended in case of old layers or critical base metals.. Equivalent in SMAW: Dur 64
CLASSIFICATION	AWS A 5.21: EN ISO 14700: T Fe16 DIN 8555: MF-10-65-GZ
SUITABLE FOR	For fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, sugar mill hammer and knives, clinker crushers, coal mill rollers, screw conveyors, sintering lines, mixer blades etc.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo	Nb	V	W	Fe
5.20	0.4	1.0	21.0	7.0	7.0	1.0	2.0	bal

WELD METAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc
AW							63-65

AW: as welded

WELDING PARAMETERS / PACKING

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

REDRYING TEMPERATURE	150°C / 24hr