

OA Mn14

CATEGORY FCAW Flux-Cored

TYPE Self-shielded and slag forming flux-cored wire for gas-shielded welding

APPLICATIONS Welding parts of manganese steel that are exposed to impact and shock-like wear

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe 9
DIN	8555: MF-7-250-KNP

SUITABLE FOR Rebuilding, buffer layers before hardfacing on steels with high carbon content, heavy impact loads, manganese steels

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Fe
0.8-1.2	13-14.5	0.3-0.5	3.5-4.5	0.4-0.7	Bal.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							200-230
SW							450

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing
	Voltage (V)	Current (A)	kg
1.2	18-22	120-200	15
1.6	20-26	160-260	15
2.8	25-28	320-400	15

REDRYING TEMPERATURE 150°C/24hr