

## OA SS 60

<b>CATEGORY</b>	FCAW Flux-Cored
<b>TYPE</b>	High-Mo alloyed flux cored wire on a „High Speed steel basis“ (HSS) for extreme hard deposits on parts subject to strong impact and high pressure, weldable without protective gas.
<b>APPLICATIONS</b>	Rebuilding wornout parts that faces wear and impact combined with increased working temperatures. (Excellent alloy for making cutting tools out of mild steel)
<b>PROPERTIES</b>	High wear resistance and similar structure as High speed tool steels. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old Hardface-layers.
<b>CLASSIFICATION</b>	AWS A 5.21: EN ISO 14700: T Fe4 DIN 8555: MF 4-60-ST
<b>SUITABLE FOR</b>	59-62 HRc hardfacing alloy for cutting edges, wood shredders, knives, recycling equipment, HSS, High speed tool steel alloy. Cutting edges on knives and share blades, pumps, mixer blades, wood shredders etc.. (Excellent alloy for making cutting tools out of mild steel)
<b>APPROVALS</b>	CE approved

### WELDING POSITIONS:



### WELD METAL ANALYSIS %

C	Mn	Si	Cr	W	Mo	V
0.80	0.40	0.60	4.50	2.00	8.00	1.50

### ALL WELD METAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							58/60

AW: as welded

### WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	19-25	160-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	23-26	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	24-27	320-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

**REDRYING TEMPERATURE** 150°C / 24hr.