

OA 550-VW

CATEGORY FCAW Flux-Cored

TYPE Medium -alloyed tubular wire on a C-Cr-Mo-W basis for high hardness up to 550°C.

APPLICATIONS Recommended for parts subject to strong mineral abrasion and erosion, .

PROPERTIES Very good abrasion resistance in combination with impact even at higher temperatures up to 550°C. To much layers should be avoided, preheat is necessary to avoid cracking. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe8
DIN	8555: MF 6-60-PT

SUITABLE FOR HRc 55-58, Cement pumps, crusher bars, hammer and blooming table rolls, mineral and brick industry.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	W	Mo
0.50	3.00	1.0	6.00	1.0	1.50

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							55-58

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spools
1.2	18-24	100-220	S-300 / Coil B-450 / Drum	15 / 30 / 300
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	25-28	320-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

REDRYING TEMPERATURE 150°C / 24hr.