

## OA 59

**CATEGORY** FCAW Flux-Cored

**TYPE** High-alloyed tubular wire on a C-Cr-Nb carbide basis for extreme hard deposits on parts subject to strong mineral abrasion, weldable without protective gas.

**APPLICATIONS** Cladding and rebuilding parts that are subject to severe abrasion.

**PROPERTIES** Extreme abrasion resistant with reasonable impact properties and temperature resistance up to 300°C. Due to the combination Cr and Nb 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 also possible.

**CLASSIFICATION**

AWS	A 5.21
EN ISO	14700: T Fe15
DIN	8555: MF 10-60-G

**SUITABLE FOR** Sand and earth moving equipment such as buckets and teeth, dredge buckets, coke hammers, crushing equipment, rockwool rolls and brick industry, cement rollers, tables, Nihard and Mohard parts without buffer layer, slurry pumps, loaders, wear plates etc.  
Equivalent in SMAW: [Dur 62S](#), [Dur 63Nb](#)

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Nb	Specials
5.00	0.50	1.00	22.00	7.00	+

**MECHANICAL 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							62-65

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool
1.6	24-28	150-350	S-300 / Coil B-450 / Drum	15 / 25 / 330
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)

**GAS ACCORDING EN 14175:** not required