





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 650°C. 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. If a buffer layer with higher hardness is required, then OA 59H should be used. Equivalent in SMAW:

Dur 64

CLASSIFICATION EN ISO 14700: T Fe16

DIN 8555: MF 10-GF-65-GZ

SUITABLE FOR For fire gratings, sintering plants, augers and blast furnace bells ,gravel washing equipment, sugar

Mn

0.4

mill hammer and knives, clinker crushers, coal mill rollers, screw conveyors, sintering lines, mixer

blades etc.

APPROVALS No Approvals Found

**WELDING POSITIONS** 

PA PB PC

TYPICAL CHEMICAL ANALYSIS OF WELD METAL

ALL WELD MECHANICAL

**PROPERTIES** 

(%)

Heat	R <sub>P0,2</sub>	Rm	A5	Hardness
Treatment	MPa	MPa	(%)	Rockwell C
As Welded /				Avg. 64

Мо

6.5

REDRYING TEMPERATURE 14

140°C / 24 hr

**GAS ACCORDING EN 14175** 





## CEWELD OA 64

OA 64 1,6MM	Туре	KG/unit	EANCode	
	BS-300	15	8720663403742	
OA 64 2,0MM	Туре	KG/unit	EANCode	
	BS-300	15	8720663403759	
OA 64 2,4MM	Type	KG/unit	EANCode	
	BS-300	15	8720663403766	
OA 64 2,8MM	Type	KG/unit	EANCode	
	BS-300	15	8720663403773	•