WEARcore 63 B-O (SK A43-OB)
open arc metal cored wire

Classifications

| EN 14700 | DIN 8555  |
| T Fe16   | MF 10-GF-65-G |

Characteristics

CrNb alloy with addition of Boron designed to resist high stress grinding and gouging abrasion. The deposit will readily show stress relief cracks.

- Microstructure: Complex carbides in an austenitic matrix
- Machinability: Grinding only
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: 2 layers maximum

Field of use

Shovel, excavator, dredge and dragline bucket lips and teeth, hammers, ripper teeth, crushing equipment, expeller screws, giratory crushers, wear plates, screens in the coal industry, etc.

Typical analysis in %

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Nb</th>
<th>B</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>5.2</td>
<td>0.2</td>
<td>1.0</td>
<td>20.3</td>
<td>6.7</td>
<td>1.0</td>
<td>balance</td>
</tr>
</tbody>
</table>

Typical mechanical properties

Hardness as welded: 65 HRC

Recommended welding parameters

<table>
<thead>
<tr>
<th>Wire diameter [mm]</th>
<th>Amperage [A]</th>
<th>Voltage [V]</th>
<th>Stick-Out [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>180 – 200</td>
<td>26 – 30</td>
<td>30 – 35</td>
</tr>
<tr>
<td>2.4</td>
<td>250 – 300</td>
<td>26 – 30</td>
<td>30 – 35</td>
</tr>
<tr>
<td>2.8</td>
<td>325 – 450</td>
<td>26 – 30</td>
<td>30 – 35</td>
</tr>
</tbody>
</table>