



655 OA

EN 14700 T Fe15

DESCRIPTION

Meltolit 655 OA is a wire for self-shielded metal arc hardfacing. High chromium cast iron deposit containing a high proportion of hard primary chromium carbides in a tough austenitic matrix. The deposit is suitable for hardsurfacing components subject to extremely severe abrasive wear and moderate impact.

Applications: For hardsurfacing components undergoing wear by earth, sand and abrasives. Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws etc. Best limited to two layers unless impact loading is small. Multi-layer deposits are possible in specific applications.

WELDING POSITIONS	CURRENT TYPE	GAS
	DC(+)	Self shielded Gas shielded M21

MECHANICAL PROPERTIES

Hardness

58-64 HRC

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr
5	1,5	1,5	27

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6
Spool(kg)	15	15
Wire feed speed(m/min)	3,7-18	1,8-12,0
Stick-out(mm)	10-25	10-25
Amperage(A)	100-250	160-320
Voltage(V)	21-28	24-30

EQUIVALENT CONSUMABLES

MMA	Meltolit 71160 E
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