

Tube Alloy A45-O

Tube Alloy A45-O is a self-shielded wire depositing a combination of large chromium carbides and small, fine columbium and alloy carbides in an austenitic eutectic matrix. It is designed to resist severe high and low stress abrasion with

minimal impact at elevated temperatures up to 760°C. The deposit will stress-relief check crack readily. The thickness should not exceed about 9mm or 2-3 layers it can also be run submerged arc with a neutral flux.

APPLICATIONS

Tube Alloy A45-O is suitable for use on blast furnace bell's burden area, fan blades, sheets in blast furnace bell, sinter breaker bars and sinter plant parts.

SPECIFICATION

DIN 8555 MF10-GF-65-GZ (nearest)

TYPICAL WELD METAL DATA

%C	%Mn	%Si	%Cr	%Cb	%Mo	%W	%V
5.5	0.2	1.0	21.0	6.5	6.5	1.5	1.0

Abrasion resistance	Excellent
Impact resistance	Poor
Machinability	Grind only
Flame cutting	Cannot be flame cut
Thickness	2-3 layers maximum
Microstructure	A combination of large chromium carbides and small fine columbium and alloy carbides in an austenite/eutectic carbide matrix
Maintains hot hardness up to 760°C	

TYPICAL HARDNESS RANGE HRC

Layer	1020 Steel	Hardness After Tempering	
		538°C	60
1	60	565°C	54
2-3	64	593°C	50

RECOMMENDED WELDING DATA

Tube Alloy A45-O can be used on DCEP

Dia mm	Current	Volts	Electrode Stickout	Deposition Rate Kg/hr
1.6	275-350	24-27	25-38	4.5
2.0	300-400	25-28	25-38	5.2
2.8	400-450	26-29	38-51	6.4

PACKING DATA

Dia mm	Item Number	Spool Mass Kg	Spool Type
1.6	077146	11.34	Spool
2.0	077147	27.2	Coil
2.8	077148	27.2	Coil

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