



ARCWEL - 630 FCAW-O
Flux cored open arc wire for hard facing of parts subject to mineral abrasion.
57--60 HRC /DIN EN 14700 : T Fe 14-60 CGT

- For wear protection in cement works, earthmoving, quarries, steel works, foundries, mining and sugar industries.
- To protect earth moving buckets, **bulldozer blades, crusher rollers, impellers, screw conveyors, mixer blades, fans, shredders, garbage crusher hammers, crusher jaws, concrete pump bodies** etc.
- Excellent for abrasion accompanied by low to medium impact
- High corrosion resistance .
- Weld deposit: High Chromium carbide, only machinable by grinding
- 630 does not require gas shielding
- It is recommended to limit the hard facing deposit to 3 layers.
- For heavier build ups we recommend to use ARCWEL 350 or ARCWEL 355 as a base or build up wire followed by 2 –3 layers ARCWEL 630

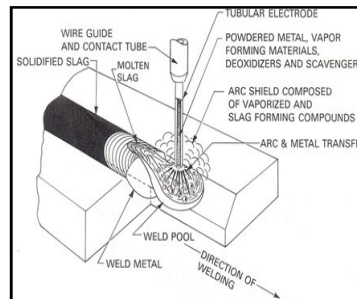
Typical weld metal composition :

C	Si	Mn	Cr	Mo	Fe
3.5-4.5	0.5-1.5	0.1-0.2	32-35	+	Bal



Sizes/ Welding parameter / Pos. 1 G/PA

Ø mm	Voltage (V)	Ampere (A)	Stick out mm
1.6	20-26	180-280	20-40
2.0	22-27	220-300	25-40
2.4	26-30	260-340	25-50
2.8	28-30	300-380	30-55



Supplied on Spools
 B/ BS 300 13-15 Kg

Disclaimer-Warranty:
 The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties. Arcwel reserves the right to alter specification without further notice.
 Health & Safety : Observe safety regulations (fumes) MSDS available on request www.arcwel.com 2017



ARCWEL 630 –SMAW

HARDFACING ELECTRODE

For protection against mineral abrasion & erosion

For wear protection in brick & clay production, mining, cement works, earthmoving, quarries, steelworks, foundries, recycling, **power generation, palm oil and sugar industries.**

Use to **protect earthmoving buckets, shredder hammers, cane rake combs, cane cutting knives, bulldozer blades, crusher blades & rollers, impellers, screw conveyors, mixer blades, concrete pump bodies, coal shearing machines, fans etc.**

- **Excellent for abrasion accompanied by low to medium impact**
- Good compressive strength, smooth deposits, slag free, high corrosion resistance.
- High metal recovery coating (160 %) allowing fast deposition
- Weld deposit is machinable by grinding only

♦ **Hardness : HRC 57- 61 / HV 650-740**

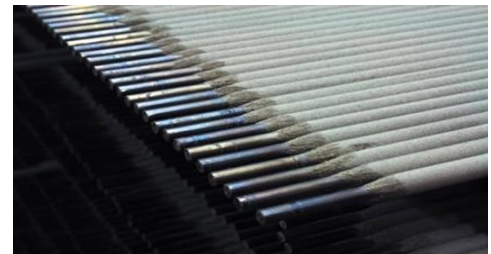
♦ **Specification. : DIN EN 14700 E Fe 14**



Typical Weld Metal Composition (wt-%)

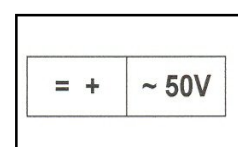
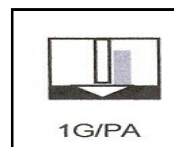
C	Si	Mn	Cr	V	Nb	Ni	Fe
2-4.	0.5-1.5	0.5-1.	28-30	<0.3	<0.5	<0.4	Base

Sizes Ø x L mm	3.2x350	4.0x450
Kg /Packet	5	6
Packets/carton	4	4
Kgs/carton	20	24
(Amp)	120-140	150-170



Welding position

Current



Note: This alloy is also available as tubular flux cored open arc wire Code : ARCWEL 630-FCAW-O

Welding recommendations .

Use SMAW electrodes in down hand Position. Hold a short arc and the electrode almost vertical. Limit build up to 2-3 layers (8-10 mm). Preheat hard base metal or large parts and use buffer layer (ARCWEL 350/355) when heavier build ups are required.

Disclaimer- Liability

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ARCWEL - 655 - FCAW-O

Flux cored open arc wire for extreme abrasion combined with high temperature

- For wear protection in cement works, earthmoving, quarries, steel works, foundries, mining and sugar industries.
- To protect rake teeth in furnaces, **tong bits** , **crusher rollers, impellers, screw conveyors, mixer blades, fans, shredders, crusher jaws, concrete pump bodies etc.**
- Excellent for abrasion accompanied by low to medium impact
- High temperature resistance . (up to 550 C
- Weld deposit: High Chromium + Niobium Carbide,
- Only machinable by grinding
- 655 does not require gas shielding
- It is recommended to limit the hard facing deposit to 2 layers.
- For heavier build ups we recommend to use ARCWEL 350 or ARCWEL 355 as a base or build up wire followed by 2 –3 layers ARCWEL 655

EN 14700 : T Fe 15-60 G

Typical weld metal composition :

C	Si	Mn	Cr	Nb	Fe
4.5-5.5	1--2.5	0.3-0.6	20-25	6-8	Bal



Sizes/ Welding parameter / Pos. 1 G/PA

Ø mm	Voltage (V)	Ampere (A)	Stick out mm
1.6	20-26	180-280	20-40
2.0	22-27	220-300	25-40
2.4	26-30	260-340	25-50
2.8	28-30	300-380	30-55



Supplied on Spools
B/ BS 300 13-15 Kg

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Health & Safety : Observe safety regulations (fumes) MSDS available on request www.arcwel.com 2017



ARCWEL 655 –SMAW

Hardfacing electrode for extreme abrasion and high temperature resistance

- ◆ For wear protection of screw conveyors, mixer blades, dredger teeth, fans, ash plows, coke chutes, crusher segments, coal mining equipment exhaust fans, rake teeth in furnaces, tong bits, concrete pump housing etc.
- ◆ Can be applied on carbon and alloy steels, manganese and cast iron.
- ◆ Excellent for abrasion and heat, accompanied by low impact
- ◆ High compress strength and good weldability
- ◆ High metal recovery electrode with a deposit rate of 200%
- ◆ **Excellent abrasion and heat resistance (up to 550 °C)**
- ◆ **Hardness; ~ 64 HRC (810 HV)**
- ◆ WEAR INDEX (Mineral Abrasion) ~0.5 %
- ◆ Outlast Carbon Steel approx. 200 X
- ◆ Weld deposit contains Niobium carbides (Hardness 2400 Vickers) for **maximum resistance to mineral abrasion**

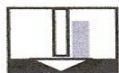
Welddeposit composition /
Classification : EN 14700 E ZFe 15

C	Si	Mn	Cr	V	Mo	Nb	Fe
4-5	+	+	23-25	+	+	6-8	Base

SIZES /PACKAGES

Dia x Length mm	3.2x350	4.0x450
Kgs/Packet	4.5	6
Packets/carton	4	4
Kgs/carton	18	24

Current (A)	140	180
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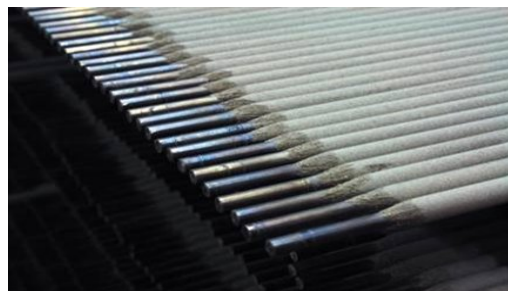
1G/PA

= + ~ 50V

Note: This alloy is also available as tubular flux cored open arc wire Code : **ARCWEL 655-FCAW-O**



Max abrasion resistance



Recommendations.

Use SMAW electrodes in down hand Position. Hold a short arc and the electrode almost vertical. Limit build up to 2 layers (8-10 mm). Preheat hard base metal or large parts and use buffer layer (ARCWEL 350/355) when heavier build ups are required. Not recommended for impact applications

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