



CEWELD OA 350

TYPE	Open Arc wire for cladding and rebuilding without protective gas.								
APPLICATIONS	320-390 HB, hardfacing and rebuilding alloy for wornout wheels, rails, tracks, tires, conveyors, crossings, bufferlayers prior to hardfacing. Excellent wear and abrasion resistance against heavy impact and shock, good machinable with carbide tools								
PROPRIÉTÉS	Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable with carbide tip tools, hardening is possible. The maximum hardness is dependent on the base metal and is usually already achieved in the first layer.								
CLASSIFICATION	EN ISO	14700: T Fe3							
	DIN	8555: MF 1-350-ST							
CONVIENT POUR	Rails repair, crossings, concrete bars, crane, railway and tram tracks, conveyors and transport surfaces, tires, bucket and loader teeth, crusher jaws, bufferlayers etc.								
AGRÉMENTS									
POSITIONS DE SOUDAGE	 PA  PB								
ANALYSE CHIMIQUE TIPIQUE DU MÉTAL DE SOUDURE (%)	C	Mn	Cr	Ni	Mo				
	0.12	1.5	1.2	2.4	0.4				
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	$R_{P0.2}$ (MPa)	R_m (MPa)	A5 (%)	Hardness				
	As Welded				350 HB				
ETUVAGE	140°C / 24 hr								

GAS ACC. EN ISO 14175



CEWELD OA 350

OA 350 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402998

OA 350 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403001