CEWELD OA 350

certilas® THE FILLER METAL SPECIALIST

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. Excelent 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 usualy 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, cruscher jaws, bufferlayers etc.

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE 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)	Rm (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