CEWELD®

OA 350

CATEGORY	FCAW Flux-Cored
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
PROPERTIES	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 250ºC. 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	AWS A 5.21: EN ISO 14700: T Fe3
SUITABLE FOR	Rails repair, crossings, concrete bars, crane, railway and tram tracks, conveyors and transport surfaces, tires, bucket and loader teeth, cruscher jaws, bufferlayers etc.
APPROVALS	CE approved
WELDING POSITIONS:	

ALL WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo	Al
0.12	1.50	0.40	1,20	2,40	0,40	1,50

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HB
AW							320-390

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool / drum	kg / pallet
1.2	21-33	100-280	S-300	15 / 300	1080 / 600
1.6	24-33	160-310	S-300	15 / 300	1080 / 600
2,4	26-35	200-350	K-415	25 / 300	1050 / 600
2,8	27-36	225-370	K-415	25 / 300	1050 / 600

REDRYING TEMPERATURE	150°C / 24 hr