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

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 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

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

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Ni	Mo
0.12	1.5	1.2	2.4	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /				Avg. 350

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

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OA 350 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663402998

OA 350 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663403001