



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. 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 usually 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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Ni	Mo
0.12	1.5	1.2	2.4	0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				350 HB

REDRYING 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