



CEWELD OA 400

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|--|--|---------------------|----------------|-----------|----------|-----|------|--|--|--|
| TYPE | Open Arc wire for buffer layers and rebuilding against high impact and pressure weldable without protective gas. | | | | | | | | | |
| APPLICATIONS | 385-415 HB, rebuilding and hardfacing alloy for extreme critical applications where extreme impact loads and surface pressure causes deformation and cracks that need to be solved. | | | | | | | | | |
| PROPRIÉTÉS | Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer. Suited for wear parts subject to heavy pressure, 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 ZFe1 DIN 8555: MF 3-400-ST | | | | | | | | | |
| CONVIENT POUR | Rebuilding wornout wheels, hammers, lime stone crushing rollers, crossings, concrete bars, crane, railway and tram tracks, conveyors and transport surfaces, kiln tire support rollers, bucket and loader teeth, crusher jaws, buffer layers prior to hard facing. | | | | | | | | | |
| AGRÉMENTS | | | | | | | | | | |
| POSITIONS DE SOUDAGE |  PA  PB | | | | | | | | | |
| ANALYSE CHIMIQUE TIPIQUE DU MÉTAL DE SOUDURE (%) | C | Si | Mn | Cr | Mo | V | Fe | | | |
| | 0.15 | 0.4 | 1.5 | 2 | 3.2 | 0.4 | Rem. | | | |
| PROPRIÉTÉS MÉCANIQUES | Heat Treatment | $R_{P0.2}$ (MPa) | R_m (MPa) | A5 (%) | Hardness | | | | | |
| | As Welded | | | | 410 HB | | | | | |
| ETUVAGE | 140°C / 24 hr | | | | | | | | | |
| GAS ACC. EN ISO 14175 | | | | | | | | | | |