



CEWELD OA 400

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	



ANALYSE CHIMIQUE TYPIQUE 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