



# 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 <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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