



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.	
PROPERTIES	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 DIN	14700: T ZFe1 8555: MF 3-400-ST
SUITABLE FOR	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.	

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	V	Fe
0.15	0.4	1.5	2	3.2	0.4	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				410 HB

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175