

OA 400

CATEGORY	FCAW Flux-Cored
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	AWS A 5.21: special alloy EN ISO 14700: special alloy DIN 8555: special alloy
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	CE approved

WELDING POSITIONS:



ALL WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo	V	Fe	micro alloys
0.12-0.18	1.3-1.7	0.35-0.45	1.8-2.3	0.5-0.8	2.5-4.0	0.35-0.45	Rem	++

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							385-415

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters				Packing	
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool / drum	kg / pallet
1.2	21-33	100-280	S-300	15 / 300	1080 / 600
1.6	24-33	160-310	S-300	15 / 300	1080 / 600
2,4	26-35	200-350	K-415	25 / 300	1050 / 600
2,8	27-36	225-370	K-415	25 / 300	1050 / 600

REDRYING TEMPERATURE 150°C / 24 hr

GAS ACCORDING EN 14175: not required