

SACW 350

CATEGORY FCAW Flux-Cored

TYPE Fluxcored SAW wire for cladding and rebuilding wornout parts.

APPLICATIONS 325-375 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 To be used with neutral flux and basischity above 1.5. Suitable fluxes are [FL 851](#) and [FL 155](#)

CLASSIFICATION
 EN ISO 14700: ~T Fe2
 DIN 8555: MF1-GF-350-P

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 CE approved

WELDING POSITIONS:



ALL WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo	Nb
0.07	1.4	0.3	4.0	0.5	0.1

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							325-375

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool / drum	kg / pallet
2,4	28-30	250-350	K-300	15 / 300	1080 / 600
3.2	29-32	300-450	K-415	25 / 300	1050 / 600
4.0	30-34	350-600	K-415	25 / 300	1050 / 600

REDRYING TEMPERATURE 150°C / 24 hr