



ARCWEL 240-SMAW

Against corrosion, friction & pressure

For maintenance, repair & buildup

- ◆ **Multipurpose (SMAW) stick** electrode for repair welding on alloy and high-alloy-steels, tool-steels, stainless steels, cast steels, manganese steel ,spring steel, and **dissimilar steel welding.**
- ◆ **High mechanical properties** and **good corrosion resistance,**
- ◆ For **rebuilding piston crowns,** heat exchangers, chassis, springs ,plates, drill bits, gears, moulds, dies, press tools, chains, crane booms, **shafts,** tools, a. rotors, extrusion screws for plastic, overlays on press tools, turbine blades, valve seats bearing housings etc..
- ◆ **Weld deposit can be machined** and will work harden in service.
- ◆ **Recommended for use as buffer layer** prior to hard facing when hard facing higher carbon content steels.

Mechanical Properties (Typical) / Class. EN 14700: ~ E Fe 11 cnz

Tensile Strength [MPa]	Yield Strength [MPa]	Elongation A [%]	Hardness As welded
800	550	25	250 - 280 HB

Weld Metal Composition (%) typical

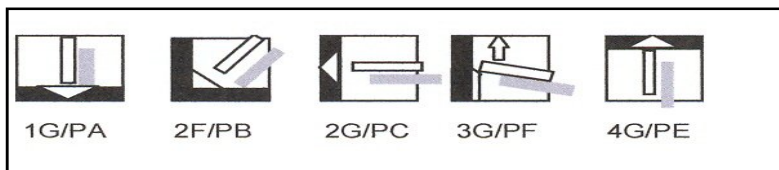
C	Cr	Mn	Ni	Mo	V	Cu	Fe
0.05-0.15	22-30	0.5-1.5	7-11	0.2-0.6	0.1	0.1	Base



Sizes /Packages

Ø [mm]	length [mm]	current range [A]	pack [kgs.]	weight / ctn. [kgs.]
2,5	300	55 - 80	4	16
3,2	350	95 - 110	5	20
4,0	350	120- 160	5	20

Welding positions



Note: This alloy is also available in wire form for GMAW, FCAW, & GTAW Welding Processes

Disclaimer/ Warranty

The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties. Arcwel reserves the right to alter specification without further notice. **Health & Safety :** Observe safety regulations (fumes) MSDS available on request www.arcwel.com e-mail: info@arcwel.at



ARCWEL 350 -SMAW

Against corrosion, friction & pressure Maintenance & repair welding alloy

- ◆ Austenitic welding alloy with high elongation and good corrosion resistance
- ◆ For rebuilding piston crowns, gears, moulds, dies, press tools, chains, crane booms, shafts, rails and rail crossings, rotors, extrusion screws for plastic, overlays on press tools, rebuilding worn bearing housings etc..
- ◆ For joining and overlaying of Hardox steels(450,500,600) and armour steel.
- ◆ Weld deposit can be machined and will work harden in service.
- ◆ Recommended for use as **buffer layer** prior to hard facing when hard facing higher carbon content steels.

Mechanical Properties (Typical)

Tensile Strength Rm [MPa]	Yield Strength Rp 0.2 [MPa]	Elongation A 5 [%]	Hardness As deposited	Hardness After workharden
610	410	32	215 - 250 HB	~450 HB

CLASSIFICATION : EN 14700 : E Fe 10 -200/400 cnz

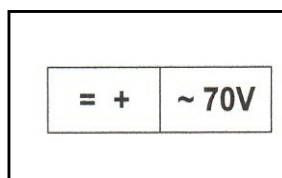
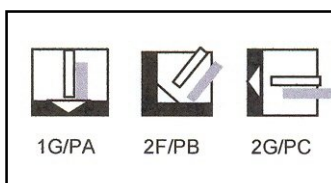
C	Cr	Mn	Ni	Mo	Cu	Fe
0.04-0.12	16-20	4-6.5	8-10	<0.5	<0.2	Bal

Sizes /Packages

Ø [mm]	length [mm]	current range [A]	pack [kgs.]	weight / ctn. [kgs.]
3,2	350	95 - 110	5.0	20
4,0	350	120- 160	6.5	26



Welding positions / Current



Note: This alloy is also available in wire form for GMAW, FCAW, & GTAW Welding Processes



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