



ARCWEL 355-SMAW

AGAINST IMPACT CAVITATION & PRESSURE

For protection against heavy impact, medium abrasion cavitation and pressure.

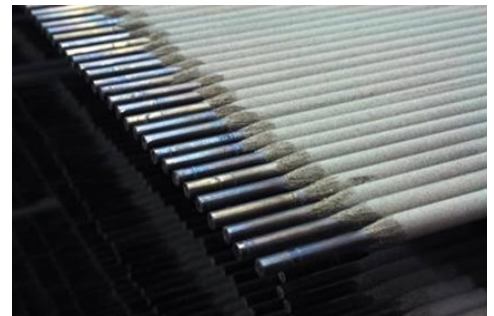
Typical applications are joining and rebuilding of

- ◆ Rail ends and rail crossings ,crusher jaws, crusher rollers, shredder hammers,
- ◆ Bulldozer buckets , tractor pads, crane wheels, grab jaws, ripper teeth, couplings etc.
- ◆ For welding and rebuilding austenitic 13% Mn- steel (Hadfield steels)
- ◆ Weld deposit is work hardening and highly resistant to cracking.
- ◆ Used as a cushion or build up layer when hard facing with Chromium carbide electrodes.
- ◆ Heavy build ups are possible. Not suitable if flame cutting is required
- ◆ Suitable for joining dissimilar steels (Manganese and construction steels)

Hardness HB As welded ~ 260	after work hardening 400-500 HB	Classification EN 14700 : E-Fe 9
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Typical weld metal composition %


C	Si	Mn	Cr	Ni	Mo	V	Fe
+	+	14-16	13-15		+		Base



Packaging and Welding Data

Sizes	3.2x350	4.0x450
Kg /Packet	5.	6.5
Packets/carton	4	4
Kgs/carton	20	26

Current (A)	120-150	170-200

Welding positions	Current		
 <small>1G/PA 2F/PB 2G/PC</small>	<table border="1"> <tr> <td>= +</td> <td>~ 70V</td> </tr> </table>	= +	~ 70V
= +	~ 70V		

Note: This product is also available as flux cored wire for FCAW open arc welding and can be used without gas shielding

Diameters available 1.6,2.4 ,2.8 and 3.2 mm

Packing: 15 kg spools



Disclaimer: 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 358 -SMAW WELDING ELECTRODE

Against Impact- Cavitation- Pressure

For protection against heavy impact, pressure & for buffer layers

Typical applications are joining and rebuilding of

- ◆ Rail ends and rail crossings ,crusher jaws, crusher rollers, shredder hammers,
- ◆ Bulldozer buckets , tractor pads, crane wheels, grab jaws, ripper teeth, couplings etc.
- ◆ For welding and rebuilding austenitic 13% Mn- steel (Hadfield steels)
- ◆ Weld deposit is work hardening and highly resistant to cracking.
- ◆ Used as a cushion or build up layer when hard facing with Chromium carbide electrodes.
- ◆ Heavy build ups are possible.
- ◆ Suitable for joining dissimilar steels (Mn and construction steels)

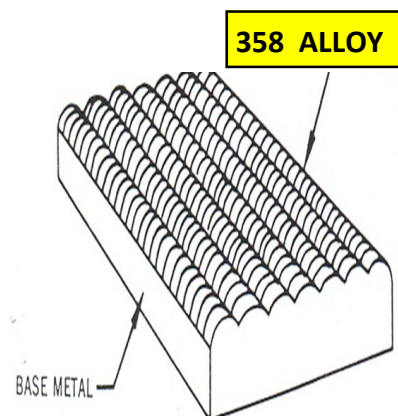
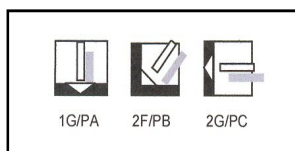
Hardness as welded ~ 240 HB	Hardness after work hardening 400-500 HB	CLASSIFICATION EN 14700: E-Fe 9
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Typical weld metal composition %

C	Si	Mn	Cr	Ni	Mo	V	Fe
<1.	<0,6	12-14	3-4	3-4	<0.3	<0.1	Base

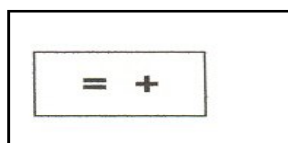
Packaging and Welding Data

Sizes	3.2x350	4.0x450
Kg /Packet	5.	6.5
Packets/carton	4	4
Kgs/carton	20	26



JAW CRUSHER REPAIR

Current (A)	120-150	170-200
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For Piston Crown rebuilding

Note: This product is also available as flux cored wire for FCAW open arc welding and can be used without gas shielding

Diameters available 1.6,2.4 ,2.8 and 3.2 mm

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