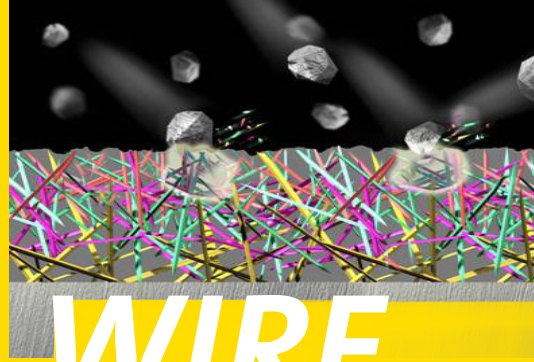


Premium Open Arc Buildup Wire for General Maintenance & Repair

TeroMatec[®] OA 3010



WIRES

- Excellent for repairing all alloyed steels
- Superior crack resistance
- Recommended for rapid build up
- Easy handling, rapid deposition and good machinability
- Exceptional toughness and impact resistance



DESCRIPTION:

Teromatec OA 3010 is recommended for rapid buildup on low and medium carbon steels. Deposits are exceptionally tough and exhibit superior crack-resistance. Rebuilt parts can readily be machined using carbide tools and can be easily shaped and cut using the oxy-fuel process.

TECHNICAL DATA:

Hardness as-deposited: 34-37 HRC (two passes)
Max. number of passes: Unlimited but practical at 1in (25mm)
Polarity: DCEP (DC+)

TYPICAL APPLICATIONS & INDUSTRY:

Rebuilding worn trunnions, steel mill wobblers & pods, shovel burns, cast steel parts, rollers, idlers.

OPEN ARC PARAMETERS

DIAMETER	AMPERAGE	VOLTAGE	WIRE STICKOUT
2.8 mm (7/64") - max. deposition	300-375	27-30	31mm - 44mm (1 1/2 ± 1/4")
2.8 mm (7/64") - thin sections	225-300	25-28	31mm - 44mm (1 1/2 ± 1/4")

Hardness Influence: In general, an increase in deposit hardness will decrease wear.

Load Influence: Wear rates typically increase as the load increases.

Speed Influence: An increase in either the part or material being moved will increase wear.

Temperature: In general, as the temperature increases the wear rate increases.

WELDING PROCEDURE:

Preparation:

Clean weld area of scale and/or oxide. A nominal preheat of 65°C (150°F) is advised if part is below 5°C (40°F) or over 25 mm (1") thick. For higher carbon steels higher preheats will be needed. Do not preheat manganese steel castings above 205°C (400°F) as this will cause time-temperature embrittlement.

Technique:

Maintain the optimum electrode stickout and hold a 75° angle from the vertical in the direction of travel. Do not weave excessively. Wide beads can cause porosity, excessive base metal overheating, and degrade the weld deposit wear properties. Back whip craters to reduce cracking tendencies and potential out-gassing.

Post-welding:

Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket or by other means. If steel composition is unknown, slow cool at a rate of 38°C (100°F) per hour.

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