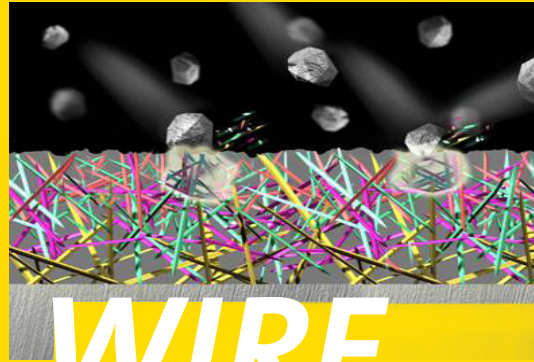


Quality Open Arc Wearfacing Wire for
Section Buildups on Massive Parts

TeroMatec® OA 3110



WIRE

- Excellent resistance to deformation through compression
- Dense, highly magnetic deposit
- Multipass deposits possible
- High deposition rate
- For semi-automatic welding using drooping-characteristic power sources



DESCRIPTION:

Teromatec OA 3110 is recommended for buildup on massive section and joining on low and medium carbon steels. Deposits are exceptionally tough and exhibit superior crack-resistance and provide cushion layer for harder coating if required.

TYPICAL APPLICATIONS:

Continuous electrode without shielding gas, for rebuilding and anti-wear coating of large parts, including guide rollers and running-gear components on tracked vehicles.

TECHNICAL DATA:

Hardness: 30-34 HRC
Max. number of passes: Unlimited but practical at 1in (25mm)
Polarity: DCEP (DC+)

WELDING PROCEDURE:

Preparation:

Clean weld area. Preheating will depend upon, size and carbon equivalent of the base material. Cool slowly down to room temperature. High carbon steels should be covered with insulation material. Do not preheat austenitic manganese steels. Maintain components as cool as possible, skip weld in order to avoid overheating.

Technique:

Maintain the optimum electrode stickout and 75° angle in the direction of travel. Excessive weave technique is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. Back whip craters to reduce crater-cracking tendencies.

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.

OPEN ARC PARAMETERS

DIAMETER	AMPERAGE	VOLTAGE	WIRE STICKOUT
1.6 mm (1/6")	120-325	23-29	0.75" - 1.5"
2.8 mm (7/64")	225-370	25-30	1.25" - 2.25"

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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