



Quality Open Arc Wearfacing Wire for
Section Buildups on Massive Parts

TeroMatec®

0A 3110



- Excellent resistance to deformation through compression
- Dense, highly magnetic deposit
- Multipass deposits possible
- High deposition rate
- Easily machined

TeroMatec® OA 3110

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

TECHNICAL DATA

Typical Values	
Hardness:	30-35 HRC
Max. number of passes:	Unlimited but practical at 1" (25mm)
Current polarity:	DCEP (DC+)

DIAMETER	AMPS	VOLTS	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"

PROCEDURE FOR USE

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.

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.

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.

