

SMAW

For Hard Surfacing

HARDFACING 350R

CLASSIFICATION : JIS Z3251 DF2A-350-R

WELDING POSITIONS : 

- Tough Machinable, Martensitic Steel Deposit
- For Rebuilding And Surfacing Steels Subjected To Metal To Metal Wear
- Metal Enriched, Rutile Type Electrode

DESCRIPTION AND APPLICATIONS

HARDFACING 350R is a smooth running, AC/DC electrode which is recommended for the multi-layer build-up and surfacing of steel components subjected to metal to metal wear and compressive loading. HARDFACING 350R deposits an air hardening C-Mn-Cr steel alloy which is machinable. Recommended for the manual arc build-up and surfacing of gears, shafts, rollers, quarry parts, track links and etc.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Fe
0.12	0.45	0.3	2.2	Bal

DEPOSIT HARDNESS

SINGLE-LAYER ONTO MILD STEEL•	TYPICAL HARDNESS 28 - 32 HRC
MULTI-LAYER	TYPICAL HARDNESS 35 - 38 HRC

- Single layer deposit hardness may vary depending on base metal type and degree of dilution.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)	
			PKT	CTN
3.2	400	100 - 150	5	20
4.0	400	140 - 200	5	20
5.0	400	170 - 250	5	20

- Recommended for DC + or AC (minimum 45 OCV) operation

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