

ULTRA HARD FACING 350

FLUX CORED WIRE

Hardfacing Wire for Low to Moderate Abrasion &
High Impact

CLASSIFICATION:

- Hardfacing Wire
- Self Shielded / Gas Shielded
- Deposit Hardness: ~ 28 – 35 HRC
- Suitable for multi-layer buildup

TYPICAL APPLICATIONS:

- Crusher rollers
- Dozer blades
- Excavator teeth
- Agricultural tools
- Railway track components

KEY FEATURES:

- Excellent resistance to moderate abrasion & impact
- Crack resistant weld deposit
- Good machinability
- Easy slag removal
- Smooth arc characteristics

TYPICAL CHEMICAL COMPOSITION OF WIRE (%):

C – 0.25

Mn – 1.5

Si – 0.6

Cr – 2.0

Fe – Bal

MECHANICAL PROPERTIES OF WELD METAL:

Hardness (HRC)

Impact Resistance

Abrasion Resistance

28–35

High

Moderate

PARAMETERS & PACKING DATA:

Ø x L mm

Amperage, A

1.2

140-250

1.6

180–320

DCEP(Electrode Positive)

Available in 15 kg spools.

Vacuum sealed for rust-free storage.



DCEP

Electrode Positive

All positions except vertical down



Use 1-2 volts lower when using
mix shielding gas