

# SUNALLOY 347 S

Hard surfacing electrode with very high metal recovery



## DESCRIPTION

Thick coated electrode for high wear-resistant facings on structural and machine parts which are subject to abrasion. Due to the high carbon, chromium and other secondary alloys contents, the resistance to wear and hardness are extremely high. Especially applicable for building-up corners and edges. The welding properties are equally good with DC and AC.

## ALLOY BASIS

Fe, C, Cr, Cb

## PROPERTIES

Hard surfacing electrode with very high metal recovery (180%). Exceptional abrasion resistance at room temperature. Easy arc control in horizontal position. No slag interference.

## APPLICATIONS

Bucket teeth and shovel lips Grizzly bars Pulverizing and crushing pant Gravel handling machinery Coal mining equipment, Screw conveyors. For hard facing of parts subject to heavy abrasion and metal-to-metal wear with moderate impact up to 510°C. Suitable for: refractory press screws, brick press screws, cement press screws, palm nut press screws, parts of crushers for friable materials, conveyor screws, impellers, dredging bucket, edge runner bottom, pug mill, knife, wing knife, auger, boring bits, blast furnace bells and hoppers.

## PROCEDURE

Prepare weld groove using SUNALLOY 109, grind surfaces to remove hard spots. Clean weld area thoroughly. Ensure electrodes are completely dry. Preheat to 200/300o C is advisable, particularly on heavier sections. Weld using a "short" arc procedure with the electrode almost vertical. A "touch" technique can be used for horizontal welding. Weaving should be limited to about 5 times electrode size. Where deposits of more than 3 or 4 layers are required, buffer layers are using SUNALLOY 601 or SUNALLOY 801 should be used. De-slag completely before over-welding.

## TECHNICAL DATA

Hardness of the weld metal (as deposited) : 62 - 63 HRC  
Deposition Rate (metal recovery) : 180%

## WELDING PARAMETERS

Size (diameter)/length (mm)	: 2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 70 - 90	120 - 140	140 - 180	180 - 220
Current	: AC/DC (+)			