

SUNHARD 350

Hard Facing Electrode

CHARACTERISTICS

SUNHARD 350 is a hard facing electrode for mild steel, carbon steel and low alloy steels where 350 BHN is required. The weld deposit is highly resistant to abrasive wear with good toughness properties. With the help of carbide tools weld deposit is machinable.

APPLICATIONS

Suitable for welding of Couplings, Cog wheels, Cold punching dies, Rail ends and crossings, Steel castings etc. Also find its applications in brake shoes, shear blades, wheels, cams, gears, pulleys, drive sprockets etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium
0.26	0.62	0.41	3.05

HARDNESS (Typical) : On second layer 360 BHN

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
3.15	350/450	100-120	5 Kg	20 Kg
4.00	350/450	140-180	5 Kg	20 Kg
5.00	450	180-220	5 Kg	20 Kg

RECOMMENDATIONS:

Use stringer bead technique and avoid high current. Short arc ensures proper alloy transfer to weld deposit. Ensure the electrodes are dry, moist electrodes should be re-dried at 125°C for one hour. Use suitable buffer layers and preheating depending on the material composition and thickness.