

SUNHARD 350LH

Hard Facing Electrode

CHARACTERISTICS

SUNHARD 350LH is a heavy coated air hardening type electrode specially designed for hard facing and building of worn out machine parts which are subjected to extremely severe service conditions involving a combination of impact and abrasion. The weld deposit is extremely hard, sound and non – machinable.

APPLICATIONS

Suitable for bamboo chipper knives. Cane cutting knives, punches, dies, drilling bits, shears and surfacing re building of mill hammers for pulverizing coat.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium
0.65	0.60	0.65	0.50

HARDNESS (Typical) : 600 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	100-130	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.