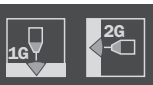
PRODUCT DATA SHEET

HARDFACING ELECTRODES

WCD 6120

Abrasocord 350



SUMMARY

- Tough, Machineable, Wear Resistant Martensitic Steel Deposit
- For Hard Surfacing Steels Subjected to Metal-to-Metal Wear Under Compressive Loading

IDENTIFICATION

Coating - Brown **Tip** - Yellow **Imprint** - WIA AC 350

CLASSIFICATION

- AS/NZS 2576: 1435-A4

DESCRIPTION AND APPLICATION

Abrasocord 350 is a smooth running, AC/DC electrode which deposits a tough wear resistant low carbon martensitic steel alloy. It is suitable for the heavy build-up and surfacing of steel components subjected to metal-to-metal wear and compressive loading such as, track components, gears and shafts, etc.

Abrasocord 350 deposits an air hardening C-Mn-Cr steel alloy which is machineable and can be readily hot forged. It offers high compressive strength and excellent resistance to impact for all types of metal-to-metal wear.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
3.2	380	100 - 140	19
4.0	380	150 - 200	22

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Fe
0.2	0.4	0.3	2.8	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Singe Layer Onto Mild Steel	Typical Hardness 30 - 35 HRc
Multi-Layer	Typical Hardness 35 - 40 HRc

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

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
3.2	5	15	24	HF35032
4.0	5	15	16	HF35040

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