

Applications

For intermetallic light abrasion hardfacing of keys clutch lugs.

Characteristics on Usage

S-350A.R is a titania type electrode which has a good workability and deposits machinable all-weld metal. Slag removability and weld metal appearance are good.

Machining can be done with high-speed steel cutter.

Quenching can be done after machining. Suitable for intermetallic abrasion.

Notes on Usage

- ① In case of hardfacing on large size cast steel, low alloy steel and high carbon steel, preheat at 150°C(302°F) and more than that.
- ② The groove repairing is prone to slag inclusion. Adjust the holding angle of the electrodes.
- ③ Dry the electrodes at 70~100°C(158~212°F) for 60 minutes before use.

Welding Position

Current



1G 2F 3G
(PA) (PB) (PF)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.10	0.50	1.00	0.010	0.007	2.40

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	370
-	-	650°C(1202°F)	280
-	-	850°C(1562°F), O.Q	430

Approval

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~140	140~190	190~240	220~300
V-up	50~80	80~130	110~160	-	-