

Metal to metal abrasion resistant

GH350R

JIS Z 3251 DF2A-350R

Product Features:

- Weld metal typical hardness approximately HRC35.
- High welding performance, low spatter loss and good bead appearance.
- Good cutting workability.

Applications:

- Suitable for hardfacing repair welding of machinery; carbon steel, cast iron and hardenable alloy steel repair and fabrication welding.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo
0.11	0.37	0.86	2.37	0.63

Typical hardness of weld metal

As welded HRC	layers
35.7	3

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450
Flat position	70~100	100~140	140~190	180~230

Note:

- 100~120°C x 1 hr baking prior to use.
- Keep short arc length while welding.
- 150°C preheating temperature on base metal before welding.

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