

Hardfacing SMAW -Severe Abrasion resistant

HARD 35

Product Features:

- Covered electrode, chromium carbide precipitation in austenite weld metal.
- High welding performance and less spatter loss.
- Good bead appearance, very low friction coefficient in weld metal surface.
- Good for moderate impact and severe wear condition.

Applications:

- Suitable for hardfacing repair welding of worn out machine parts subjected to heavy abrasion and moderate impact conditions such as impactor, screw rod, wheel wing parts, drill bit, bulldozer, agitator blade etc.

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

| C | Si | Mn | Cr |
|------|------|------|------|
| 3.40 | 1.00 | 0.30 | 32.0 |

Typical hardness of weld metal

| Carbon steel HRC | Manganese steel HRC | layers |
|------------------|---------------------|--------|
| 59 | 56 | 2 |

Size (mm) & recommended welding parameters (A)

| Diameter / Length | 3.2/350 | 4.0/400 | 4.8/350 | 5.0/350 |
|-------------------|---------|---------|---------|---------|
| Flat position | 100~150 | 150~200 | 170~230 | 180~240 |

Note:

- 250~300°C x 1 hr baking prior to use.
- Max. 2 layers.
- Good for welding on carbon steel, low alloy steel and manganese steel base metal.
- Abrasion resistant temperature $\leq 500^{\circ}\text{C}$.