

# PROWELD HF-350 *For Metal to Metal and Sand Abrasion*

## Classification

DIN 8555 : E 1-UM-350

## Applications

Surfacing of shafts, rollers and bulldozer idlers and sprockets.

## Characteristics

PROWELD HF-350 is a general purpose rutile coated hardfacing electrode depositing a tough chromium manganese alloy weld metal sufficiently hard to resist serious deformation under fairly heavy impact and rolling loads, yet with good resistance to medium abrasive wear. Recommended for hardfacing applications where maximum hardness consistent with reasonable machinability is required. Also suitable as a buffer layer and for building up multi-layer deposits on badly worn components.

## Typical Chemical Composition of Deposited Metal (%)

| C    | Mn   | Cr   |
|------|------|------|
| 0.12 | 1.00 | 3.30 |

## Typical Hardness of Deposited Metal

| Vickers (HV) | Rockwell C (HRC) | (As-welded)    |
|--------------|------------------|----------------|
| 320          | 32               | Single layer   |
| 350          | 35               | Multiple layer |

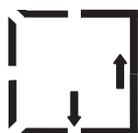
## Sizes & Recommended Current Range (AC or DC +)

| Diameter/ Length (mm) | 3.2/350     | 4.0/400 | 5.0/450 |
|-----------------------|-------------|---------|---------|
| Welding Position      | Current (A) |         |         |
| F                     | 90~125      | 140~180 | 170~240 |
| V                     | 90~115      | 120~150 | -       |

## Guideline in Usage

1. Use dry electrodes only. Damp electrodes should be re-dried at 70~120°C for 60 minutes before use.
2. Preheating at more than 150°C is required to surface low alloy steels, high carbon steels, etc.

## Welding Positions



*Flat butt and vertical up only*