

# **S-350A.R**

COVERED ARC WELDING ELECTRODE  
FOR HARDFACING OF INTERMETALLIC ABRASION



## ❖ Specification

JIS Z3251

DF2A-350-R

## ❖ 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. Maching can be done with high speed steel cutter. Quenching can be done after machining. Suitable for intermetallic abrasion.

## ❖ Note 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.



# S-350A.R

## Mechanical Properties & Chemical Compositions of all-Weld Metal

### ❖ Typical Chemical Composition of All-weld Metal(wt%)

size Mm(in)	Chemical Composition (%)					
	C	Si	Mn	P	S	Cr
4.0 X 400 (5/32 X 16)	0.10	0.50	1.00	0.010	0.007	2.40

### ❖ Typical Mechanical Properties of All-Weld Metal

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

### ❖ Available sizes and Recommended Current

Diameter, 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)
Recommended current range ( AC or DC+)	Flat (1G-PA)	55 ~90	90 ~140	140 ~190	190 ~240	220 ~300
	Vertical Up	50 ~80	80 ~130	110 ~170	-	-

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