

Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : E1-UM-350
EN 14700 : E Fe1

General Description

AS SD-350 is a heavily coated basic electrode particularly used for wear conditions where impact stresses are considered. It gives a weld metal that is resistant to deformations of high rolling forces including metal-to-metal friction. Weld metal is air hardenable and can be machined with carbide cutting tools. Hardness varies with respect to the number of passes and cooling rate. It has about 115 % metal recovery.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr
0.10	0.50	0.70	3.5

Mechanical Properties, Typical, All Weld Metal

Hardness : 325 - 350 HRC

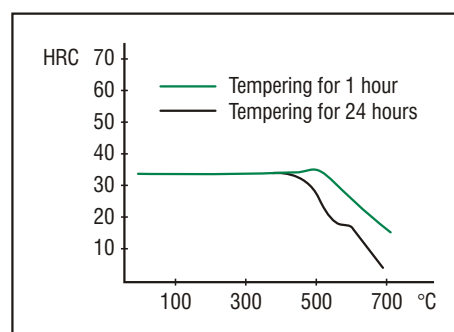
Approvals

GOST, SEPRO, TSE

GL (*)

Applications

It is used for hardfacing of rollers, gears, rail crossings, switch points, brake shoes and crane wheels. Joining of heat treatable steels having a tensile strength of 80-90 kg/mm² is another application area.



Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+) ; AC min 70 V

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
3.25	350	110 - 140	3440	5.0 / 145	5
4.00	450	150 - 190	6770	6.4 / 95	6
5.00	450	190 - 240	10080	6.6 / 65	6



1G/PA



2F/PB