

**Technical data sheet**

011121MBA

Cored welding wire

**HARDFACE 350-O****CLASSIFICATION**

EN 14700: T Fe1

**DESCRIPTION**

- Tubular wire for self-shielded metal arc hardfacing
- Low-alloy steel deposit
- Suitable for rebuilding in multiple layers without limit
- The weld deposit is machinable and crack-free

**APPLICATIONS**

HARDFACE 350-O is used for rebuilding and hardfacing components subjected to metal-metal wear and moderate abrasion.

**Examples**

Punches, railway tracks and crossings, press and die tooling, caterpillar tracks, crane and mine car wheels etc.

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Mo	Al
0.17	2	0.8	2.2	0.25	1.4

Structure: bainite / martensite

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness – 3-layer deposit on mild steel: 35 – 38 HRc

**CONDITIONS OF USE**

Current type	Shielding
DC+	Self-shielded

**OPERATING CONDITIONS**

Diameter (mm)	Current (A)		Voltage (V)		Stick-out (mm)	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 30	28	25 - 50	30
1.6	150 - 350	270	24 - 30	28	25 - 50	30
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 500	400	28 - 32	30	25 - 50	40

Recovery: 90 %

**WELDING POSITIONS**

Flat, half up, half down

**PACKAGING**

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.