

Technical data sheet <small>011121MBA</small>	Cored welding wire ROBODUR K 350-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe1

DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Medium-hard martensitic deposit can be oil-quenched
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

APPLICATIONS

ROBODUR K 350-G is used for surfacing and rebuilding parts subjected to high impact and high compressive stresses

Examples

Track pads and rollers, moulds, dies, gear teeth, mill roll coupling shaft ends

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.15	1.5	0.7	2	0.2

Microstructure: bainite / martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: As welded, 3-layer deposit on mild steel: 350 HB
Oil quenched at 810°C / 850°C: 500 HB

Direct polarity (DC-) reduces dilution and favours high hardness.

CONDITIONS OF USE

Current type	Shielding gas
DC-, DC+ or pulsed	M12: Ar + 0.5 – 5 % CO ₂
	M13: Ar + 0.5 - 3% O ₂
	M20: Ar + 5 – 15 % CO ₂
	M21: Ar + 15 – 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	110 - 300	16 - 32	12 – 25 mm	10 - 20 l/min.
1.6	130 - 350	16 - 32	12 – 25 mm	10 - 20 l/min.

Recovery: 98%

WELDING POSITIONS

ROBODUR K 350-G is suitable for both downhand and positional welding by adapting transfer mode and welding parameters as for solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 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.