



### ABRASOCORD 350



- ▶ Tough, Machineable, Wear Resistant Martensitic Steel Deposit
- ▶ For Hard Surfacing Steels Subjected to Metal-to-Metal Wear under Compressive Loading

#### Identification

**Coating** - Brown

**End Tip** - Yellow

#### Classifications

AS/NZS 2576            1435-A4

WTIA Tech Note 4    1435-A4

#### Description & Applications

ABRASOCORD 350 is a smooth running, AC/DC electrode which deposits a tough wear resistant low carbon martensitic steel alloy. It is suitable for the heavy build-up and surfacing of steel components subjected to metal-to-metal wear and compressive loading such as, track components, gears and shafts, etc.

Abrasocord 350 deposits an air hardening C-Mn-Cr steel alloy which is machineable and can be readily hot forged. It offers high compressive strength and excellent resistance to impact for all types of metal-to-metal wear.

#### Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
3.2	380	100 - 140	19
4.0	380	150 - 200	22
5.0	450	190 - 240	24

\*Recommended for DC+ or AC (minimum 45 0CV) operation

\*\* Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

#### Typical All Weld Metal Chemical Analysis

C	Mn	Si	Cr	Fe
0.2	0.4	0.3	2.8	Bal

#### Typical All Weld Metal Mechanical Properties

Single Layer onto Mild Steel	Typical Hardness 30-35 HRC
Multi-Layer	Typical Hardness 35-40 HRC

Single layer deposit hardness may vary depending on base metal type and degree of dilution.

#### Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton		
3.2	5	15	24	HF35032
4.0	5	15	16	HF35040
5.0	5	15	9	HF35050

#### Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.\*

\*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.