



# PRODUCT DATA SHEET

## HARDFACING ELECTRODES

WCD 6120

### Abrasocord 350



#### SUMMARY

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

#### IDENTIFICATION

**Coating** - Brown **Tip** - Yellow **Imprint** - WIA AC 350

#### CLASSIFICATION

- > AS/NZS 2576: 1435-A4

#### DESCRIPTION AND APPLICATION

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 *(A)	ARC VOLTAGE RANGE **(V)
3.2	380	100 - 140	19
4.0	380	150 - 200	22

\*Recommended for DC +/- or AC (minimum 45 OCV) operation.  
 \*\*Voltage is determined by arc current and electrode arc length.  
 Arc voltage shown is typical and is 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 ANALYSIS

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 NO.
	PACKET	CARTON		
3.2	5	15	24	HF35032
4.0	5	15	16	HF35040

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