

S-350A.R

JIS Z3251 DF2A-350-R

TYPE : Rutile

Applications

For rebuilding or worn steel parts and as a buffer layer prior to application of hardfacing.

Characteristics on Usage

S-350A.R is a rutile type electrode which has a good workability and deposits machinable all-weld metal. Slag removability and weld metal appearance are good. Machining can be done with high-speed steel cutter. Quenching can be done after machining.

Notes on Usage

- 1) In case of hardfacing on large size cast steel, low alloy steel and high carbon steel, preheat at minimum 150°C.
- 2) The groove repairing is prone to slag inclusion. Adjust the holding angle of the electrodes.
- 3) Dry the electrodes at 70~100°C for 60 minutes before use.

Surfacing Position



D/H Hor.

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.10	0.50	1.00	0.010	0.007	2.40

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C	Postheat	Heat Treatment.	Hardness(HB)
150	-	-	370
-	-	650°C	280
-	-	850°C, O.Q	430

Approval

I Packing

Packet 5 kg
Carton 5 kg x 4 : 20kg

Sizes Available and Recommended Currents (Amp.)

Size mm	3.2	4.0	5.0
Length mm	350	400	400
F	90~140	140~190	190~240
V-up	80~130	110~160	-

Diam.	5kg Pack
3.2mm	HKS-350AR32
4.0mm	HKS-350AR40

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