

TALARC HF350

CLASSIFICATION

AS SPECIFICATIONS	EN SPECIFICATIONS
AS2576: 1435-B6	EN 14700: S Fe2

ALLOY TYPE

Copper-coated solid wire for hard-facing.

APPLICATIONS

Copper-coated solid wire for hard-facing suitable to restore surfaces to be subjected to metal-metal wear. Deposit hardness of approx. 350 Brinnel is obtained, but is dependent on base material type and the number of deposited layers. This wire can also be used as a buffer layer prior to the application of higher hardness/abrasion resistant hardfacing. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.07	0.50	0.40	0.010	0.010	5.80	-	0.60	-

TYPICAL MECHANICAL PROPERTIES

GAS	Hardness
	(HB)
MIX	~ 350

WELDING GUIDELINES

Machinability by grinding wheel and possible quenching at 880°C oil, annealing at 850°C.

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN ISO 14175)

Welding positions: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)		1.2	
Volts (V)		18 ÷ 32	
Intensity (A)		100 ÷ 350	

Diam.	15kg Spool
1.2mm	INMHF3501215

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