

FLUX CORED WIRE : HARDFACING

SARTHAK HF 350

Applications

It is for rebuilding of worn machinery parts, deposit surfaces are suitable for metal to metal rolling and sliding contact of low / high speed gear teeth shaft rail links rollers, wheel etc.in Mining & Civil Engineering industries.

Characteristics on Usage

A low alloyed flux core wire designed for building up crack free weld deposit and are machinable with carbide tipped tools. Deposited weld metal gives the hardness 30 – 40HRC.

Welding Positions



1G

Recommended Stick Out

20 - 40 mm

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %	V %	Mo %
Spec. Reqd.	0.10-0.30	0.50-2.0	1.0 max	1.80-3.80	0.35 max	1.0 max

Mechanical Properties Of Weld Metal

**HARDNESS
ON III rd
LAYER**

30 – 40 HRC

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal	
	(A)	(V)
1.20-1.60	200-250	26-32
2.00-2.40	250-350	26-32

Packing

1) 15 kgs.vaccum packed plastic spool for 1.20/1.60 mm 2) 10 Kgs.vaccum packed plastic spool for 2.00/2.40 mm