



## PHILARK PH 330 LH

*Coated Electrode for High Strength Low Alloyed Steels*



### General Description

PHILARK PH 330 LH is a heavily coated basic electrode. It is suitable for joint welding applications of non-alloyed and medium carbon steels, fine grained steels such as St 70 and cast steels up to GS-70. The weld metal has a high resistance against hard and dynamic forces.

Especially it is ideal for multi pass welding connections, which has high strength and high impact properties, high creep resistance between -50 and +350°C. Also provides low spatter, easy machinable and high resistant weld seams against hot crack formation.

### Mechanical Properties of Weld Metal

Tensile Strength : 58-62 kg/mm<sup>2</sup>

Yield Strength : 50-55 kg/mm<sup>2</sup>

Elongation (L=5d) : 25-30 %

Hardness : 210-230 HB

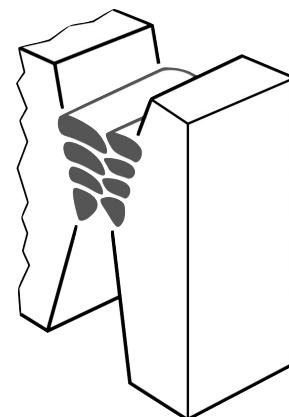
Impact (ISO-V): 190 J (+20°C)  
: 80 J (- 50°C)

Area Reduction : 75-80 %

Pressure									
Impact									
Mechanical Strength									
Heat									
Machinability									

### Typical Applications

- Welding of rotary kilns in cement industry
- Joint welding on parts working up to 350°C
- Joining of parts with truck chassis on earth moving equipments
- Joint welding on press constructions
- Joint welding on mills and crushers
- Filling of cast steels and worn out machine parts
- Welding applications in cold environments.



Joining of Heavy Sections

### Welding Parameters

Current Type and Polarity : AC/DC(+)

Welding positions: All positions

Diameter [ mm ]	3.15	4.0	5.0
Length [ mm ]	350	350	350
Current [ A ]	180-220	200-275	250-300

PHILARK ALLOYS

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