



PHILARK PH 350 S

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

It is a High alloyed rutile type austenitic-ferritic electrode containing 29/9 Cr-Ni-Cobalt special manual electrode for joining a broad range of difficult-to-weld metals including special, austenitic-manganese, air hardening materials for dissimilar joining. It is also extremely useful for repairs where the base metal is unknown grade steels.

Mechanical Strength	■	■	■	■	■
Crack Resistance	■	■	■	■	■
Heat input	■	■	■	■	■

Mechanical Properties of Weld Metal

Tensile Strength : 80 - 84 kg/mm²

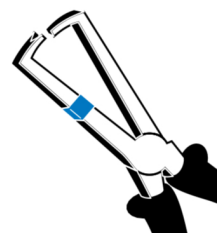
Yield Strength : 61 - 63 kg/mm²

Elongation (L=5d) : 20 - 25 %

Hardness : 250 - 300 HB

Typical Applications

- include rebuilding gear teeth,
- repairing cracks in casing, buffering layers
- repairs on earth moving and drilling equipment
- rebuilding worn shafts
- Forging dies
- Cutting tools
- Extrusion and hydraulic cylinders
- Joining stainless steels to carbon steels and low alloy steels
- Joining austenitic manganese steels to carbon steels and low alloy steels.



Repair of Broken Parts

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	40-70	70-100	90-140

PHILARK ALLOYS

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