



PHILARK PH 350 SGS

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

PHILARK PH 350 SGS deposits a Cr-Ni-Mo based stainless steel weld metal. It is designed for welding large, high strength steel components requiring fast multi-layer deposits with crack resistance. It is ideal for repairing difficult-to-weld steels and for putting down buffer layers before filling up with hardenable deposits. It can be used as a buffer layer on high manganese Hadfield steel and for surfacing where some resistance to impact and battering is required under corrosive conditions.

Mechanical Strength	
Crack Resistance	
Corrosion	

Mechanical Properties of Weld Metal

Tensile Strength : 76 - 82 kg/mm²

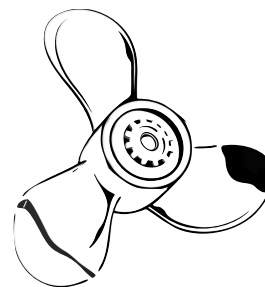
Yield Strength : 58 - 62 kg/mm²

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

Hardness : 220 - 260 HB

Typical Applications

- Press cylinders in plastic and food industries
- Earth moving equipments
- Hydraulic cylinders
- Injection moulds
- Extrusion screws
- Turbine blades
- Valve seats for superheated steam
- Heat exchangers
- Coal washing screens
- Wear plates
- Bucket tooth
- Dies, gears, shafts, tools



Impellers

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	90-120	130-150	180-210

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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