



RASI HF 350R

HARD FACING WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI - HF 350 R design to give a hard and wear resistance deposit of approximate 350 brinell. Is a rutile coated AC/DC(-) electrode producing an a hardening type weld metal for hard facing of carbon and alloy steels.

APPLICATIONS

RASI - HF 350 R the weld deposit is machinable and is used for surfacing / joining of gears, pinions, shafts, Couplings, rails, conveyers , pulleys etc.

HARDNESS

HARDNESS ON THREE LAYER DEPOSIT 300 - 350 BHN

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.20 - 0.4%	Silicon - 0.6%
Manganese - 0.4 - 0.8%	Cr - 2 - 3%

Note: Single Values shown above are maximum

PHYSICAL PROPERTIES

Machinability - GOOD, only with carbide tool.
Abrasion Resistance - EXCELLENT
Impact Resistance - GOOD.
Corrosion Resistance - N.A.

WELDING CURRENT : AC / DC (-)

Ø 2.50 mm - 60-90 Amps
Ø 3.15 mm - 100-140 Amps
Ø 4.00 mm - 140-180 Amps
Ø 5.00 mm - 180-220 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

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