

GRIDUR 350

AN EXTRUDED, MEDIUM-HEAVY COATED, HARD FACING ELECTRODE.

IDENTIFICATION

Gridur 350

DESCRIPTION

An extruded, medium-heavy coated, hard facing electrode. For building up the parts, not more than 3 layers of deposition should be made. If more layers are required, an inter layer with GEECON PURPLE is recommended. A buffer-layer with GEECON PURPLE is recommended for application on high carbon steel or hard base materials.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	P	S	Cr
0.15 - 0.25	0.35 - 0.45	1.0 max	0.03 max	0.03 max	2.0 - 3.0

WELDING PROPERTIES

- Striking and restricting properties are good. The arc is stable and the slag is easy to remove.
- Weld metal surface is smooth and shows fine ripples.
- Weld deposit is machinable.

TYPICAL APPLICATIONS

- Impact and Abrasion resistant hard facing of machine parts made out of mild steel, structural steels and cast steel.
- Rails, couplings, rollers, pulleys, wheel rims, conveyer screws, axles, shafts, hammers etc.

APPLICABLE FOR

- Impact and Abrasion resistant hard facing of machine parts made out of mild steel, structural steels and cast steel.

HARDNESS OF WELD METAL

325-400 BHN, depending on parent metal and welding conditions.

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (-)	Packing / Box (kg)
2.5	350	70 - 90	5 x 4 = 20
3.15 / 3.20	450	90 - 110	5 x 4 = 20
4	450	120 - 150	5 x 4 = 20
5	450	170 - 220	5 x 4 = 20