

GRIDUR 350



IDENTIFICATION : GRIDUR 300

SPECIFICATION : An extruded, medium-heavy coated, hard facing electrode.

HARDNESS OF WELD METAL :

225-275 BHN, depending on parent metal and welding conditions.

WELDING INSTRUCTIONS :

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

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.

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	0.4-0.7

APPLICABLE FOR :

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

TYPICAL USES :

Rails, couplings , rollers, pulleys, wheel rims, conveyer screws, axles, shafts, hammers etc.

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (-)	PACKING PER BOX	WEIGHT 1000 Pcs
3.15	450	90-110	120X4=480	44.63
4.00	450	120-150	65X4=260	60.00
5.00	450	160-190	55X4=220	93.74