

EH 350

Covered Electrode for Hardfacing Applications -

Standards

TS EN 14700	E Z Fe2
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Properties and Applications

Thick basic-covered electrode for producing wear resisting hardfacing deposits, which is particularly resistant to metal-to-metal wear, impact and abrasion. Suitable for reconditioning of rails, rail crossings and switch points, wearing parts such as dredger parts, polygon edges, bearing surfaces, striking tools, die tyres, wheel flanges, slide surfaces subject to heavy wear, reconditioning of lower dies, punches, cutting blades, table and rolling rolls. Weld metal can be machined only by using sintered hard metal tipped tools. A tough buffer layer using ESB 40 or EI 307B electrodes is solely required in case of very crack sensitive base metal. Can be welded in all positions, except vertical-down. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.

Typical Chemical Values of Weld Metal

Type of Analysis	Fe
Weld Deposit	92.25

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	90-130
4.00x450	140-180

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
18020NDEM2	3.25x350	71 pcs	2.64	3	8.10	Plastic Box
18020SFEM2	4.00x450	90 pcs	6.74	3	20.40	Plastic Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 350°C for 2 hours.