

ROBODUR K 350-G

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

- Seamless copper coated tubular wire for gas shielded metal arc hardfacing
- Low alloy martensitic deposit
- Excellent weldability

APPLICATIONS

Robodur K 450-G is used for surfacing and rebuilding parts subjected to impact and high compressive stresses.

Examples

Rebuilding and buffering of forged or rolled mechanical components: transmission shafts, rolls or chocks for steel making, roller bearing seats, rollers for gantry cranes, gear teeth, forging tools and dies.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe
0.15	1.50	0.70	2.00	0.20	Rest

Structure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 350 HB

CONDITIONS OF USE

Current type	Shielding gas
DC (+)	M12 / M13 / M20 / M21

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	100 - 300	24 - 32	12 - 25	10 - 20
1.6	150 - 300	24 - 32	12 - 25	10 - 20
2.0	200 - 400	24 - 32	12 - 30	10 - 20
2.4	250 - 450	24 - 32	12 - 30	10 - 20

Recovery: > 95 %

WELDING POSITIONS

Robodur K350-G, up to Ø 1.6 mm, is suitable for downhand as well as for positional welding by adapting transfer mode and welding parameters as for solid wires

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm		2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg