

DUROARC 350-G

DESCRIPTION

DUROARC 350-G is a medium hardness build-up wire with excellent compressive strength. Recommended for application where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

SPECIFICATIONS

Wire Type:

Metal-cored, Gas-shielded
Deposits are slag-free

Weld Deposit Properties:

Hardness: HRC 33 - 37
Maximum Deposit Thickness: Unlimited
Deposits can be flame cut
Machinable with carbide tools

APPLICATIONS

- Shovel boom heels
- Coupling boxes
- Logging arch wheels
- Dredge bucket pins
- Spindles
- Saw carriage wheels
- Ladder role bearing box
- Wobblers
- Cable sheaves
- Dredge driving tumblers
- Wheels on mine cars
- Gears shafts and keyways
- Slag ladle cars
- Conveyor chain links
- Dredge ladder rolls
- Crane wheels
- Driving sprockets
- Carbon steel pump shells
- Tractor undercarriage idlers and rollers
- Driving tumblers
- Dragline chains
- Trencher drive segments and rollers
- Hot metal cars
- Kiln trunnions
- Ingot buggies
- Shovel carrier

WELDING PARAMETERS (POLARITY - DC STRAIGHT)

	SHORT - ARC		SPRAY - ARC	
	.045"(1.2mm)	1/16"(1.6mm)	.045"(1.2mm)	1/16"(1.6mm)
Current <i>amps</i>	150-250	175-350	200-400	230-450
Voltage (DCSP) volts	22-26v	24-28v	30-35v	32-38v
Gas	Ar/Co2	Ar/Co2	Ar/Ox	Ar/Ox
Gas Flow cfh (<i>l/min</i>)	25-30 (12-15l/min)	25-30 (12-15l/min)	40-45 (19-22 l/min)	40-45 (19-22 l/min)
Stickout inch (<i>mm</i>)	1/2"-1(12-25mm)	1"-11/2"(25-38mm)	5/8"(15mm)	3/4"(18mm)

PULSED SPRAY ARC WELDING (Use 98/2 Argon/Oxygen with 120pps)						
Diameter	.045"(1.2mm)			1/16"(1.6mm)		
	Current <i>amps</i>	200	220	250	250	275
Peak <i>amps</i>	350	375	425	350	375	400
Voltage (DCSP) volts	24v	25v	26v	24v	25v	26v
Gas Flow cfh (<i>l/min</i>)	40-45 (19-22 l/min)			40-45 (19-22 l/min)		
Stickout inch (<i>mm</i>)	5/8" (15mm)			3/4" (18mm)		

When welding out-of-position, use the lower ranges of voltages and amperages: 16-19 volts and 100 - 150 amps

PACKAGING

Diameter	.045"(1.2mm)	1/16" (1.6mm)	7/64" (2.8mm)
25 Lb. Spools	Standard	Standard	NA
55 Lb. Coils	NA	Available	Standard

Alternative Welding Electrode - Duroarc 21