



PRIME H350

For Hard Surfacing

CLASSIFICATIONS:
EN ISO 14700: E Fe1
JIS Z3326: YFCrA-C-350

PRIME H350 is a gas-shielded flux cored wire that is suitable for intermetallic abrasion and soil abrasion with light impact. Ideal for application such as various wheels, shafts, gears, steel casting rollers and part of bulldozers, etc. In order to minimize cracking, should obey the preheat and interpass temperature.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)					
Shielding gas	C	Mn	Si	Cr	Mo
CO ₂	0.11	1.90	0.64	1.48	0.49

HARDNESS OF WELD METAL				
WELDING CONDITION		VICKERS (Hv)	ROCKWELL (H _{RC})	SHORE (Hs)
As Welded	Preheating-Interpass Temp. 150-200°C	290-320	28-32	41-45

- Single layer deposit hardness may vary depending on the base metal type and degree of dilution.

SIZES AND RECOMMENDED CURRENT RANGE (DC+)		
DIAMETER Ø	1.2mm	1.6mm
Voltage (V)	23-33	27-35
Current (A)	140-220	200-300
Spool (Kg)	15	15