

CLASSIFICATION

DIN 8555 : E1-UM-350
EN 14700 : E Fe1

GENERAL DESCRIPTION

L SD-350 is a heavily coated basic electrode particularly used for wear conditions where impact stresses are considered. It gives a weld metal that is resistant to deformations of high rolling forces including metal-to-metal friction. Weld metal is air hardenable and can be machined with carbide cutting tools. Hardness varies with respect to the number of passes and cooling rate. It has about 115% metal recovery.

APPROVALS

GOST, SEPRO, TSE
GL

(*)

APPLICATIONS

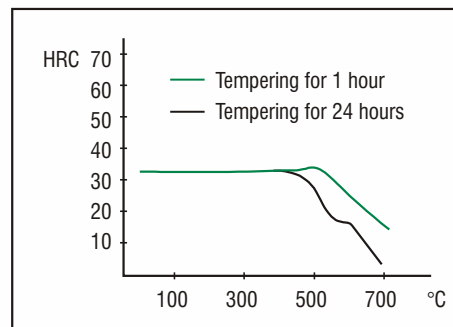
It is used for hardfacing of rollers, gears, rail crossings, switch points, brake shoes and crane wheels. Joining of heat treatable steels having a tensile strength of 80-90 kg/mm² is another application area.

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr
0.10	0.50	0.70	3.50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness : 325 - 350 HRC



WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+) ; AC min 70 V

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export BoxBox Weight [kg]
3.25	350	110 - 140	3440	5.0 / 145	5
4.00	450	150 - 190	6770	6.4 / 95	6
5.00	450	190 - 240	10080	6.6 / 65	6



Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

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