

**SK 350-S**

Unalloyed and low-alloyed steels

**Classifications**

SAW cored wire

DIN 8555

UP 1-350

**Characteristics**

Rebuilding and hardfacing alloy for Carbon steel parts.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

**Field of use**

Sliding metal parts, gear teeth, undercarriage links, rollers and idlers, shafts, bushing.

**Typical analysis in %**

C	Mn	Si	Cr	Mo	Nb	Fe
0.07	1.4	0.3	4.0	0.5	0.1	balance

**Typical mechanical properties**

Hardness as welded: 320 HB

**Form of delivery and recommended welding parameters**

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
3.2	325 – 450	26 – 30	35 – 40	1.1	40 – 50