

METHARD 350

350HV HARDNESS MMA ELECTRODE FOR SURFACING

PRODUCT DESCRIPTION

MMA surfacing electrode with a rutile metal powder type flux made on low carbon core wire.
Recovery is about 120% with respect to core wire, 65% with respect to whole electrode.

SPECIFICATIONS

BS EN 14700 E Fe1 (Nearest classification)

ASME IX QUALIFICATION

QW432 F-No

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Mo
Typical	0.3	0.2	0.2	3	0.1

ALL-WELD MECHANICAL PROPERTIES

Typical hardness as-welded assuming at least three layers on mild steel base plate:

Vickers (HV)	380-410
Rockwell (HRC)	39-42
Brinell (HB)	360-390

Preheat and dilution will affect hardness in the first two layers but will have little effect in subsequent layers.

OPERATING PARAMETERS, DC +VE OR AC (OCV: 70V MIN)

Diameter (mm)	3.2	4.0	5.0
min. A	80	100	140
max. A	140	180	240

PACKAGING DATA

Diameter (mm)	3.2	4.0	5.0
Length (mm)	450	450	450
kg/carton	18.6	18.9	18.0
Pieces/carton	471	234	147

STORAGE

3 hermetically sealed ring-pull metal tins per carton, with unlimited shelf life. Direct use from tin is satisfactory.
For electrodes that have been exposed:

Redry 200 – 300°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total.

Storage: Recommended ambient storage conditions for opened tins (using plastic lid): < 60% RH, > 18°C.

FUME DATA

Fume composition, wt % typical:

Fe	Mn	Cr	F	OES (mg/m ³)
16	5	1	18	1