



PHILARK PH 357

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

PHILARK PH 357 has a manganese alloyed stainless steel deposit containing Cr-Ni- Mn-Mo which is a work hardening alloy. It is used for build-up applications and cushion layers prior to harder overlays, and for a wide range of steel, low alloy steel and 12-14% austenitic manganese steel components subjected to severe impact combined with high pressure. Steel deposit will also resist a wide range of corrosive conditions and cavitation. Deposits exhibit a smooth even shaped bead, high metal recovery rates and ease of slag removal. The electrode can be deposited in contact with the workpiece.

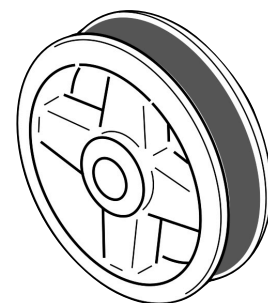
Pressure	■	■	■	■	■
Impact	■	■	■	■	■
Abrasion	■	■	■	■	■
Heat	■	■	■	■	■
Corrosion/Cavitation	■	■	■	■	■

Mechanical Properties of Weld Metal

Tensile Strength : 64 - 66 kg/mm²
Elongation (L=5d) : 40 - 44 %
Hardness : 160 - 200 HB (as welded)
400 - 440 HB (cold worked)

Typical Applications

- Site machinery
- Welding and repairing 12-14% manganese steels - Crusher jaws
- Tractor sprocket tooth
- Guides and rollers on tracked vehicles
- Armour plates
- Perforated plating on ore-sorters
- Gyratory crusher cones
- Conveyor rollers
- Crusher cylinder hooks
- Dozer cutting edges.
- Bucket lips and sides.
- Impactors, hammers
- Joining austenitic manganese steels to carbon steels - Stainless cladding carbon steels and low alloy steels



Conveyor Rollers

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	85-110	140-160	210-240

PHILARK ALLOYS

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