



PHILARK PH 360

Coated Electrode for High Strength Low Alloyed, Work hardening



General Description

PHILARK PH 360 is a high manganese Austenitic type Hatfield steel structure weld metal with improved ductility and toughness and also high compression and tensile strength. Especially is suitable for buffer layers prior to harder overlays, 12-14% manganese including steels, hardenable alloyed steels and steels with limited weldability. PHILARK PH 360 is resistant against high loads of impact, pressure and low forced abrasion wearing. Becomes harder working under impact with cold deformation.

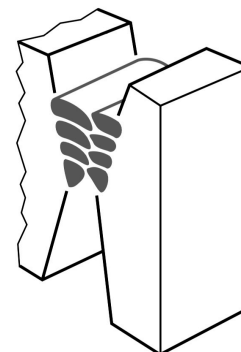
Bonding	
Crack Resistance	
Machinability	

Mechanical Properties of Weld Metal

Compressive Strength: 170 kg/mm²
Tensile Strength : 80-85 kg/mm²
Yield Strength : 60 kg/mm²
Elongation (L=5d) : 40-45 %
Hardness : 160-170 HB (as welded)
 400-425 HB (work hardened)
Impact (ISO-V) : 125 J (-60 deg C)

Typical Applications

- Joining and welding operations of Mn-steels and joining of these steels with medium carbon steels and alloyed steels
- Armor plates
- Crushers and grinders working under impact and/or under pressure (crushers, crusher cones, crusher hammers) and including parts
- Mine, soil and earth moving equipments
- Machine parts working under impact (hammer drill)



Joining and Build Up for Heavy sections

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	3.15	4.0
Length [mm]	350	350
Current [A]	80-135	135-180

PHILARK ALLOYS

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