

## MA 350

<b>CATEGORY</b>	GMAW-GTAW Solid wires				
<b>TYPE</b>	Welding wire for rebuilding parts and for buffer layers before hardfacing.				
<b>APPLICATIONS</b>	Rebuilding machine parts before hardfacing and cladding crane and or train wheels to achieve a wear resistant layer against high pressure caused by metal to metal friction.				
<b>PROPERTIES</b>	MA 350 offers almost full hardness in the first layer and can be applied without any risk of cracking. Multiple layers or sandwich layers are possible before hardfacing and will help to increase the hardness (wear resistance) from the hardface layer.				
<b>CLASSIFICATION</b>	AWS	A 5.21: ER Fe-1			
	EN ISO	14700: S Fe2			
	DIN: W.Nr.	~1.7363			
	DIN	8555: MSG-5-GZ-350			
<b>SUITABLE FOR</b>	350 HB hardfacing alloy, sprocket wheels, rebuilding, crushing hammers, Rebuilding machine parts before hardfacing and cladding crane and or train wheels to achieve a wear resistant layer against high pressure caused by metal to metal friction.				
<b>APPROVALS</b>	CE approved				
<b>WELDING POSITIONS:</b>					
<b>WELD METAL ANALYSIS % (M21)</b>					
C	Mn	Si	Cr	Mo	
0.07	0.90	0.70	6.00	0.90	
<b>MECHANICAL PROPERTIES</b>					
Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V	Hardness HB
AW				-20°C    -40°C    -60°C	320-380
AW: as welded					
<b>WELDING PARAMETERS / PACKING</b>					
	Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	
1.0	18-27	160-260	K-300	15	
1.2	21-31	220-300	K 300	15	
1.6	24-33	260-380	K 300	15	
<b>REDRYING TEMPERATURE</b>	not required				