Mangalam®

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MANGALAM®
H.F. Electrodes - 350 R

Reliable, High-Hardness Welding For Heavy-Duty Use

The MANGALAM HF 350 is a rutile-coated electrode that offers a machinable deposit with a hardness of 350 VPN, providing medium resistance to abrasion. Perfect for industrial applications that require toughness, this electrode ensures longevity and precision in hard-facing components.

Ideal For Wear-Resistant Components

- Gears Teeth In Cement Plants
- Shafts & Journals
- Excavators & Axles
- Conveyor Parts & Rollers
- Tractor Wheels
- Plough Shares

Packing Data

SWG Size	Size (Mm)	Electrodes/Packet	Electrodes/Carton	Current (Amps)
12	2.50 x 350	225	900	70 - 90
10	3.15 x 450	130	520	100 - 140
8	4.00 x 450	85	340	140 - 180
6	5.00 x 450	50	200	180 - 220

Chemical Composition Of Weld Metal (%)

Element	Composition (%)
Carbon (C)	0.20 - 0.50
Manganese (Mn)	0.20 - 0.40
Silicon (Si)	0.20 - 0.40
Chromium (Cr)	2.00 - 3.00

Mechanical Properties Of All Weld Metal

Property	Value
Hardness	350 BHN Min (after third layer)

Current Conditions

Operates on AC current.

Operates on DC current.