

AKD35

HRC=36

Description: Low hydrogen sodium and low alloy steel surfacing electrode, with excellent weldability and machinable.

Application: Used for surfacing on parts with heavy abrasion accompanied under room temperature and non-corrosive condition.

Typical Chemical Composition(%):

	C	Cr	Mo	Mn	Si	P	S
Requirement	0.04-0.20	0.50-3.5	1.5	0.50-2.0	1.00		
Actual Result	0.11	1.8	0.40	1.35	0.80	0.027	0.006

Recommended welding parameters:

Diameter/ mm	3.2	4.0	5.0	—
Electrode Length (mm)	350	400	400	—
Welding Current (A)	80-120	120-170	160-200	—

Notes on Usage:

1. Manual electrode must be baked under 300-350'°C for 1hr before welding.
2. Water, rust and oil on the surface of base metal/ part must be removed completely Welding with short arc length is appropriate.
3. For avoiding blowhole, the manual electrode goes backward 2mm before arc starting and then weld forward. Before extinguishing arc, stay a while and weld backward 5mm.