

**PRIME  
WELD**

**PRIME H33-0**

**For Hard Surfacing**

**CLASSIFICATIONS:**  
EN ISO 14700: E Fe15  
JIS Z3326: YFCrA-C-700

PRIME H350 is a self-shielded chrome carbide flux cored wire for hardfacing components subject to extremely severe abrasive wear and moderate impact and moderate corrosion resistance. The deposit contains high proportion of hard primary carbon and eutectic carbides in a tough austenitic matrix. Design to use in hardfacing palm oil mill screw and high pressure kernal worms. Ideal also palm oil expeller screw, dredge pump impellers, crusher cones and sugar mill crusher hammers.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)					
C	Mn	Si	Cr	P	S
4.51	1.05	0.85	25.01	0.013	0.011

HARDNESS OF WELD METAL				
WELDING CONDITION		VICKERS (Hv)	ROCKWELL (H <sub>RC</sub> )	SHORE (Hs)
As Welded	Preheating-Interpass Temp. 300°C	700-780	56-62	81-87

- Single layer deposit hardness may vary depending on the base metal type and degree of dilution.

SIZES AND RECOMMENDED CURRENT RANGE (DC-)		
DIAMETER Ø	1.6mm	2.0mm
Voltage (V)	27-35	26-33
Current (A)	200-300	200-350
Spool (Kg)	15	15