



FLUX CORED WIRE FOR HARDFACING

YAWATA HRC 35 is a flux cored welding wire. Flat, butt and horizontal welding position. Excellent weld quality, uniformed beads and low spatter. Mostly used for rollers, sprockets, idlers for tractors and power shovel.

Chemical Composition

C	Si	Mn	P	S	Cr	Mo	V
0.21	0.46	2.13	0.013	0.022	5.65	0.48	0.22

Typical Hardness of Deposited Metal

Rockwell C (HRC)	Vickers (HV)	Heat Treatment
~38	~350	As Welded

Size & Recommended Current Range

Welding Position	1.2mm	1.6mm
Current (A)	220~280	250~320
Voltage	28~30	30~32
Shielding Gas	CO2	CO2

Packing

15kg spool

Welding Positions



Flat Butt and Horizontal