



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

350HT Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
825 Groves Street
Lowell, NC 28098
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

Washington Alloy 350 HT (Build-up and Hardfacing – Heavy Impact and Mild Abrasion) is our “general purpose” build-up and hardsurfacing wire. The weld deposit of 350 HT is a low alloy deposit with a martensitic structure. It is machinable and forgeable. A good balance of impact resistance and abrasion resistance as well as hardness make Our 350 HT an excellent choice where only one wire is desired for build-up and hardsurfacing. (Not to be used as an underlayment prior to subsequent hardfacing). Excellent for overlaying carbon steel shafts, Steel Shovel Pads, gear teeth and sprockets.

IMPACT RESISTANCE ; Very Good ABRASION RESISTANCE ; Fair
COMPRESSION ; Good

TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.045	195- 300 -475	125- 205 -265	20- 24 -28	1/2-1”	35-45
0.052	150- 270 -320	140- 255 -320	22- 25 -29	1/2-1”	40-50
1/16”	135- 240 -240	250- 310 -350	23- 25 -29	3/4-1.75”	40-50

Procedures may vary with change in position, base metals, filler metals, equipment, and other changes.
1-2 VOLTS LOWER USED WITH MIXED GAS

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

Carbon	0.163	Chromium	1.50
Manganese	1.24	Iron	Balance
Silicon	0.36	Molybdenum	0.18
Phosphorus	0.016		
Sulfur	0.006		
Hardness Rockwell C = 34-39			

AVAILABLE SIZES: THF 350HT= Spools of .045, 1/16”
Other sizes available – please inquire



SPECIFICATIONS; Internal, JIS Z 3326-2007 YF2A-C-350

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