

Applications

For intermetallic abrasion, hardfacing of fans, upper rollers and sprockets.

Characteristics on Usage

Machining is possible, in general. Hardness increases by quenching after machining. It is suitable for intermetallic abrasion and moderate impact abrasion.

Notes on Usage

- ① Preheating is unnecessary, in general, large weldments of hardening property should be preheated.
- ② In case of high cooling speed, preheat or postheat to prevent difficulty of machining caused by hardening.
- ③ Pay attention to blow hole at the arc starting.
- ④ Dry the electrodes at 350~400°C (662~752°F) for 60 minutes before use.

Welding Position

Current



1G 2F 3G
(PA) (PB) (PF)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.26	0.82	1.44	0.015	0.009	1.88

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C (°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	390
-	-	650°C (1202°F) Tempering	280
-	-	850°C (1562°F), O.Q	470

Approval

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg (44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~140	140~190	190~240	220~300
V-up	50~80	80~130	110~170	-	-