

# S-450B.B

JIS Z3251 DF2A-450-B

TYPE : Basic

## Applications

For intermetallic abrasion and light soil abrasion. Hardfacing of idlers, rollers, bulldozer blades, sprockets, caterpillar links, crushers, dipper teeth and conveyors.

## Characteristics on Usage

The deposited metal of S-450B.B has the mixed metal structure of austenite and martensite and it has a high grade of hardness and machining is a little bit difficult.

## Notes on Usage

- ① Preheat at 150°C(302°F) and more than that in general.
- ② In case of multi-layer build-up welding, under-lay with low hydrogen type carbon steel electrodes.
- 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



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

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.30	1.06	0.56	0.019	0.010	1.64	0.63

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp.°C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	420
300 (572)	-	-	380
-	-	650°C(1202°F) 6hr.F.C	410
-	-	625°C(1157°F) 6hr.F.C	330

## 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	-	-