

Classifications

KS D 7035 : DFMA-250-B
 JIS Z 3251 : DFMA-250-B

Description

- Covering is high titania type for hardfacing of crushers, high manganese rails, buckets, bulldozer parts and build-upof parts subject to serene impact and abrasion.
- The deposited weld metal has austenite structure.
- Extremely ductile deposited weld metal.
- When the base metal of 13% Mn steel is hardened, cut off the hardened zone before welding.
- Redry the electrode at 300-400°C for 1-2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.52	0.30	12.10	0.018	0.012	0.02	0.10	0.20	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Interpass temp. 150°C	Work hardenability
HV	225	510
HRC	16.9	49.8
HS	33	66.5

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F	90~130	140~180	190~240	220~300