

Typical applications

Hardfacing of roller and shear used at elevated temperature, ingot tongs and forged metal mould.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The deposited weld metal has the microstructure of carbide precipitation in the austenite matrix.
- ② Preheat at about 150°C and maintain the interpass temperature above 150°C for multilayer welding of low alloy steels and high carbon steels.
- ③ Redry the electrode at 300~350°C for 30~60 minutes

Typical chemical composition of all-weld-metal (%)

| C | Si | Mn | Cr | Ni | Mo | W |
|------|------|------|------|-----|-----|-----|
| 0.29 | 0.15 | 1.25 | 16.4 | 8.2 | 4.5 | 5.4 |

Typical mechanical properties of all-weld-metal

| Conditions | As welded | |
|------------|----------------------|----------------------------------|
| | Continuous surfacing | Interpass temperature max. 150°C |
| HV | 250 | 320 |
| HRC | 22.2 | 32.2 |
| HS | 36 | 45 |

Sizes available and recommended currents (AC or DC ⊕)

| | | | |
|-------------|-----------|---------|---------|
| Dia. (mm) | 3.2 | 4.0 | 5.0 |
| Length (mm) | 350 | 350 | 350 |
| Amp. | F 100~120 | 120~150 | 150~180 |

Welding positions

Approved by