

KM-100

JIS DF2A-250-R
KS DF2A-250-R

FOR HARDFACING

Typical applications

Hardfacing of shafts, tires, gears, crane wheels, etc.

Coating

High titania type.

Characteristics on Usage

- ① Easy slag removal.
- ② Beautiful, smooth bead appearance.
- ③ Preheat at 150~200°C only for low alloy steel and high carbon steel.
- ④ Redry the electrode at 70~100°C for 30~60 minutes prior to use.
- ⑤ Extremely machinable the deposited weld metal.

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

C	Si	Mn	P	S
0.11	0.42	0.98	0.016	0.013

Typical hardness of all-weld-metal

Conditions	As welded	
	Continuous surfacing:	Interpass temperature max.100°C
HV	225~240	245~265
HRC	16~20	21~25
HS	33~34	35~38

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.	F 80~120	140~170	170~210	200~250

Welding positions



Approved by