

FOR HARDFACING

JIS DF2A-350-R
KS DF2A-350-R

KM-100C

Typical applications

Hardfacing of shafts and clutch lugs.

Coating

High titania type.

Characteristics on Usage

- ① Easy slag removal and smooth bead appearance.
- ② Preheat at 150°C and over only for cast steel, low alloy steel and high carbon steel.
- ③ Extremely machinable the deposited weld metal.
- ④ Redry the electrode at 70~120°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr
0.19	0.44	0.74	2.6

Typical hardness of all-weld-metal

Conditions	As welded	Heat treated	
	Interpass temperature 150°C	900°C oil quenching	650°C stress relief
HV	350	435	300
HRC	35.5	44.1	29.8
HS	48	59	42

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 90~120	140~170	190~230	220~280

Welding positions



Approved by