

FOR HARDFACING

JIS DF2A-250-B
KS DF2A-250-B

KM-250

Typical applications

Hardfacing and repairing of worn parts such as shafts, gears, wheels, etc.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Stable arc, smooth bead appearance and easy slag removal.
- ② High abrasion resistance and impact resistance.
- ③ Preheat at about 150°C only for multilayer welding of low alloy steel and high carbon steel.
- ④ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	P	S
0.18	0.69	2.28	0.013	0.009

Typical mechanical properties of all-weld-metal

Conditions	As welded	Heat treated	
	Interpass temperature 150°C	900°C oil quenching	650°C stress relief
HV	278	395	250
HRC	26.8	40.3	22.2
HS	39	54	36

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 90~130	140~180	180~240	220~300

Welding positions



Approved by