

KM-300

JIS DF2A-300-B
KS DF2A-300-B

FOR HARDFACING

Typical applications

Hardfacing of shafts, roller, spindle, crane wheel, etc.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Good usability.
- ② Good machinable deposited weld metal.
- ③ Preheat at about 150°C only for multilayer welding of low alloy steels and high carbon steels.
- 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	Cr
0.20	0.60	1.48	0.7

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	308	408	280
HRC	30.8	41.6	27.1
HS	43	56	40

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 80~130	140~180	170~240	240~300

Welding positions



Approved by