

KM-300R

JIS KS DF2A-300-R
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FOR HARDFACING

Typical applications

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

Coating

High titania type.

Characteristics on Usage

- ① Excellent slag removal and smooth bead appearance.
- ② Preheat at about 150°C only for multilayer welding of low alloy steels and high carbon steel.
- ③ Redry the electrode at 70~100°C for 30~60 minutes prior to use.

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

| C | Si | Mn | Cr |
|------|------|------|-----|
| 0.20 | 0.28 | 0.30 | 2.4 |

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 | 420 | 285 |
| HRC | 30.8 | 42.7 | 27.8 |
| HS | 43 | 57 | 41 |

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