

FOR HARDFACING

JIS DF2B-350-B  
KS DF2B-350-B

# KM-350

## Typical applications

Hardfacing of fans, upper rollers, shafts and sprockets.

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① Machining is possible in general.
- ② Hardness increases by quenching after machining.
- ③ Suitable for intermetallic abrasion and moderate impact abrasion.
- 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
0.36	0.65	0.74	2.0

## 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	356	440	300
HRC	36.1	44.5	29.8
HS	49	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 90~130	140~180	190~240	220~300

## Welding positions



Approved by