

FOR HARDFACING

JIS DFMA-250-B
KS DFMA-250-B

KM-900

Typical applications

Hardfacing of crushers, high manganese rails, buckets, bulldozer parts and build-up of parts subject to severe impact and abrasion.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The deposited weld metal has austenite structure.
- ② Extremely ductile deposited weld metal.
- ③ When the base metal of 13% Mn steel is hardened, cut off the hardened zone before welding.
- ④ Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	P	S
0.52	0.30	12.1	0.018	0.012

Typical mechanical properties of all-weld-metal

Conditions	As welded	Work hardenability
	Interpass temperature 150°C	
HV	225	510
HRC	16.9	49.8
HS	33	66.5

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