

FOR HARDFACING

JIS DF3B-600-BR
KS DF3B-600-BR

KSB-2

Typical applications

Hardfacing of dies, clutch cams and metal mould.

Coating

Lime titania type.

Characteristics on Usage

- ① Excellent working efficiency.
- ② Excellent slag removal and restriking properties.
- ③ Excellent heat-resisting, crack-resisting, wear-resisting and impact-resisting properties.
- ④ In the case of multilayer build-up welding base plates of hardening properties, underlaying with low hydrogen type carbon steel electrodes.

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

C	Si	Mn	Cr	Mo	V
0.50	0.09	0.52	6.1	1.8	0.4

Typical mechanical properties of all-weld-metal

Conditions	As welded		
	Continuous surfacing	Interpass temperature max.100°C	Preheating 200°C, Continuous surfacing
HV	570	650	580
HRC	53.6	57.8	54.1
HS	71	78	72

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp.	F	80~100	120~150	160~200

Welding positions



Approved by