

Classifications

EN 14700:2005	: E Fe 1
KS D 7035	: DF2A-250-R
JIS Z 3251	: DF2A-250-R

Description

- Covering is high titania type for hardfacing of shafts, tires, gears, crane wheels, etc.
- Easy slag removal.
- Beautiful, smooth bead appearance.
- Extremely machinable the deposited weld metal.
- Preheat at 150~200°C only for low alloy steel and high carbon steel.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.11	0.42	0.98	0.016	0.013	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Continuous surfacing	Interpass temperature max. 100°C
HV	225~240	245~265
HRC	16~20	21~25
HS	33~34	35~38

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. (A)	F	80~120	140~170	170~210	200~250