

**Classifications**

KS D 7035 : DFWA-700-S  
 JIS Z 3251 : DFWA-700-S

**Description**

- Hardfacing of cutter knives, shovel teeth, cutter for coal, concrete cutters and earth drills.
- The deposited weld metal is harder than other kinds of deposited weld metal.
- Extremely excellent heavy soil abrasion resistance.
- The deposited weld metal has tungsten carbide alloy.
- Machining is impossible.
- Preheat at 300°C and high over.
- Postheat treat at about 600°C immediately after welding.
- Redry the electrode at 70~120°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
2.98	0.60	1.88	0.022	0.014	0.04	0.02	0.01	48.0

**Typical mechanical properties of all-weld metal**

Conditions	As welded	
	Interpass temp. max. 350°C	
HV	820	
HRC	64.7	
HS	90	

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	90~130	120~180	170~230