

Classifications

KS D 7035 : DF2A-300-R
 JIS Z 3251 : DF2A-300-R

Description

- Covering is high titania type for hardfacing of shaft, roller, spindle, crane wheel, etc.
- Excellent slag removal and smooth bead appearance.
- Good machinable the deposited weld metal.
- Preheat at 150°C only for multilayer welding of low alloy steell 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
0.20	0.28	0.30	0.025	0.022	0.03	2.40	0.01	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded		Heat treated	
	Interpass temp. 150°C	900°C oil quenching	650°C stress relief	
HV	308	420	285	
HRC	30.8	42.7	27.8	
HS	43	57	41	

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	80~130	140~180	170~240	240~300