

Classifications

EN 14700:2005	: E Fe 1
KS D 7035	: DF2A-350-R
JIS Z 3251	: DF2A-350-R

Description

- Covering is high titania type for hardfacing of shaft and clutch lugs, etc.
- Easy slag removal and smooth bead appearance.
- Extremely machinable the deposited weld metal.
- Preheat at 150°C and over only for cast steel, 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
0.19	0.44	0.74	0.015	0.011	0.02	2.60	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	350	435	300
HRC	35.5	44.1	29.8
HS	48	59	42

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	90~120	140~170	190~230	220~280