

Classifications

KS D 7035 : DF2B-450-B
 JIS Z 3251 : DF2B-450-B

Description

- Covering is low hydrogen type for hardfacing of idlers, rollers, bulldozer blades, sprockets, caterpillar links, crushers, dipper teeth and conveyors, etc.
- The deposited weld metal has typical martensite structure and high grade of hardness and ductility as welded.
- Machining is impossible as welded.
- Preheat at 150°C and over in general.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

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

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.38	0.84	1.56	0.014	0.011	0.02	2.52	0.03	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded		Heat treated (furnace cooling)	
	Interpass temp. 150°C	Interpass temp. 300°C	550°Cx6Hr.	625°Cx6Hr.
HV	452	408	443	348
HRC	45.5	41.6	44.8	35.8
HS	60	56	59	48

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	130~170	170~230	220~280