

Classifications

KS D 7035 : DFMA-250-B
 JIS Z 3251 : DFMA-250-B

Description

- Covering is high titania type for hardfacing of crushers, high manganese rails, buckets, bulldozer parts and build-upof parts subject to serene impact and abrasion.
- The deposited weld metal has austenite structure.
- Extremely ductile deposited weld metal.
- When the base metal of 13% Mn steel is hardened, cut off the hardened zone before welding.
- 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 |
|------|------|-------|-------|-------|------|------|------|------|
| 0.52 | 0.30 | 12.10 | 0.018 | 0.012 | 0.02 | 0.10 | 0.20 | 0.01 |

Typical mechanical properties of all-weld metal

| Conditions | As welded | |
|------------|-----------------------|--------------------|
| | Interpass temp. 150°C | Work hardenability |
| HV | 225 | 510 |
| HRC | 16.9 | 49.8 |
| HS | 33 | 66.5 |

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 | 90~130 | 140~180 | 190~240 | 220~300 |