

S-350B.B

COVERED ARC WELDING ELECTRODE
FOR HARDFACING OF INTERMETALLIC ABRASION
& SOIL ABRASION



❖ Specification

JIS Z3251

DF2A-400-B

❖ Applications

For intermetallic abrasion, hardfacing of fans, upper rollers and sprockets.

❖ Characteristics on Usage

Machining is possible, in general. Hardness increases by quenching after machining. It is suitable for intermetallic abrasion and moderate impact abrasion.

❖ Note on Usage

1. Preheating is unnecessary, in general, large weldments of hardening property should be preheated.
2. In case of high cooling speed, preheat or postheat to prevent difficulty of machining caused by hardening.
3. Pay attention to blow hole at the arc starting.
4. Dry the electrodes at 350~400°C (662~752°F) for 60 minutes before use.



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Mechanical Properties & Chemical Compositions of all-Weld Metal

❖ Typical Chemical Composition of All-weld Metal(wt%)

size Mm(in)	Chemical Composition (%)					
	C	Si	Mn	P	S	Cr
4.0 X 400 (5/32 X 16)	0.26	0.82	1.44	0.015	0.009	1.88

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hea Treatment.	Hardness (HB)
150(302)	-	390
-	650°C(1202°F) Tempering	280
-	850°C(1562°F), O.Q	470

❖ Available sizes and Recommended Current

Diameter, mm(in)		2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length, mm(in)		350(14)	350(14)	400(16)	400(16)	450(18)
Recommended current range (AC or DC+)	Flat (1G-PA)	55 ~90	90 ~140	140 ~190	190 ~240	220 ~300
	Vertical Up	50 ~80	80 ~130	110 ~170	-	-

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