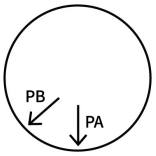
S-600B.B

Classification

JIS Z 3251 DF2B-600-B

Welding Positions





Features

- Under-lay with low hydrogen type carbon steel electrode
- Preheat at more than 150°C(302°F)
- Suitable for soil abrasion
- Martensite structure (All-weld metal)

Polarity

AC or DC ±

Application Areas

- Hardfacing of rollers, gears, crane wheels and abrasive parts

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Mo
0.42	0.94	2.14	0.020	0.008	2.49	0.01

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness(HB)
150(302)	540
300(572)	500
600(1,112)	450

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
2.6 (3/32)	350 (14)	55~90	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2 (1/8)	350 (14)	90~140	
4.0 (5/32)	400 (16)	140~190	
5.0 (3/16)	400 (16)	190~240	
6.0 (15/64)	450 (18)	220~300	