

**Classifications**

JIS Z 3326 : YF3B-C-500

**Description**

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include transfer rollers and idlers, crane wheels
- In order to minimize cracking, should obey the preheat and interpass temperature

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

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

Shielding gas	C	Si	Mn	P	S	Cr	Mo
CO <sub>2</sub>	0.19	2.06	0.35	0.014	0.012	5.26	0.59

**Typical mechanical properties of all-weld metal**

	Hv	Typical value HRC	Hs	Interpass Temp(°C)	Remarks
Example (CO <sub>2</sub> )	450~600	45~55	59~74	200	As weld

\* Composition and hardness depend upon dilution. Single layer deposit hardness depend upon base metal and/or build-up material.

**Package**

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	10, 15, 20		