

**Classifications**

KS D 7035 : DF3B-600-BR  
JIS Z 3251 : DF3B-600-BR

**Description**

- Covering is lime titania type for hardfacing of dies, clutch cams and metal mould.
- Excellent working efficiency.
- Excellent slag removal and restriking properties.
- Excellent heat-resisting, crack-resisting, wear-resisting and impact-resisting properties.
- In the case of multilayer build-up welding base plates of hardening properties, under-laying with low hydrogen type carbon steel electrode.
- Redry the electrode at 70~120°C for 30~60 minutes prior to use.

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

C	Si	Mn	P	S	Ni	Cr	V	W
0.50	0.09	0.52	0.021	0.012	0.04	6.1	0.4	1.8

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

Conditions	Continuous surfacing	As welded Interpass temp. max.100°C	Preheating 200°C, Continuous surfacing
HV	570	650	580
HRC	53.6	57.8	54.1
HS	71	78	72

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	80~100	120~150	160~200