

Description

- Covering is lime titania type for hardfacing of hot roller dies, tong punch and hot cutting knife, etc.
- The deposited weld metal has the microstructure of a fine carbide precipitation in austenite matrix.
- The high temperature hardness over 600°C is high, so it has excellent abrasion-resistance.
- Machining is possible in general.
- Good bead appearance and restriking properties, preheating is not necessary in general, but preheat at 150°C and over only for high carbon steels and low alloy steels.
- 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	Mo	W
0.30	0.48	12.4	0.016	0.014	0.02	11.8	1.5	1.8

Typical mechanical properties of all-weld metal

Conditions	As welded
HV	310
HRC	31
HS	43

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	4.0	5.0
Length	(mm)	400	400
Amp. (A)	F	140~170	190~230