

S-350B.B

Type : Basic

Conformances

JIS Z3251 DF2A-400-B

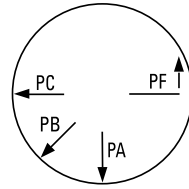
Applications

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

Features

- Medium abrasive resistance, impact resistance
- Machining possible
- Low spatter
- Good bead appearance
- Hardness increased by quenching after machining

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.26	0.82	1.44	0.015	0.009	1.88

Typical Mechanical Properties of All-Weld Metal

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

Typical Welding Parameters / Amp.(A)

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)
F & HF	55-90	90-140	140-190	190-240	220-300
V-up, OH	50-80	80-130	110-160	-	-