

S-711

Type : Basic

Conformances

JIS Z3251 DFCrA-600-BR

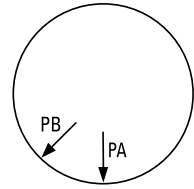
Applications

- Mills to crush clinker in cement industry
- Screws in oil industry

Features

- Good wear resistance
- Austenite structure containing Cr-Carbide
- Machining impossible (As welded)
- Preheat at more than 150°C(302°F)

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
3.47	0.90	1.11	0.018	0.014	33.87

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment	Hardness (HB)
≥300 (572)	-	-	610

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	400 (16)
F & HF	90~140	140~190	190~240

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX