

## **S-260A.B**

COVERED ARC WELDING ELECTRODE  
FOR HARDFACING OF INTERMETALLIC ABRASION



## ❖ Specification

JIS Z3251

DF2A-300-B

## ❖ Applications

For intermetallic light abrasion, hardfacing and repairing of worn parts of shafts, gears, wheels, etc.

## ❖ Characteristics on Usage

Stable arc. Beautiful bead appearance. Good flow and easy removal of the slag. High abrasion resistance and impact resistance.

## ❖ Note on Usage

1. Preheating is unnecessary, in general, in case of multi-layer welding of low alloy steel and high carbon steel, preheat at about 150°C(302°F).
2. Adopt back step method or strike arc on a small steel plate prepared for this particular purpose for preventing blow hole at the arc starting.
3. Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.



# S-260A.B

## Mechanical Properties & Chemical Compositions of all-Weld Metal

### ❖ Typical Chemical Composition of All-weld Metal(wt%)

size Mm(in)	Chemical Composition (%)					
	C	Si	Mn	P	S	Cr
4.0 X 400 (5/32 X 16)	0.15	0.68	2.15	0.015	0.007	0.05

### ❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hea Treatment.	Hardness (HB)
150(302)	-	260
-	650°C(1202°F) Tempering	240
-	850°C(1562°F), O.Q	380

### ❖ Available sizes and Recommended Current

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)
Recommended current range ( AC or DC+)	Flat (1G-PA)	55 ~90	90 ~140	140 ~190	190 ~240	220 ~300
	Vertical Up	50 ~80	80 ~130	110 ~170	-	-

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