

S-600B.B

COVERED ARC WELDING ELECTRODE
FOR HARDFACING OF INTERMETALLIC HEAVY ABRASION
& SOIL ABRASION



❖ Specification

JIS Z3251

DF2B-600-B

❖ Applications

For intermetallic heavy abrasion and soil abrasion.
Hardfacing of lower rollers and bucket edges.

❖ Characteristics on Usage

S-600B.B is an electrode depositing weld metal of typical martensite structure. It is suitable for soil abrasion. The weld softens with the heat.

❖ Note on Usage

1. Preheat at 150°C(302°F) or more than that in general.
2. In case of multi-layer build-up welding or welding base metal of hardening property, underlay with low hydrogen type carbon steel electrodes.
3. Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.



S-600B.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	Mo
4.0 X 400 (5/32 X 16)	0.54	1.06	1.64	0.026	0.010	4.02	1.38

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness (HRc)
-	53.5

❖ 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

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.