

## Applications

For intermetallic light abrasion, hardfacing and repairing of worn parts such as 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.

## Notes 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.

## Welding Position



1G 2F 3G  
(PA) (PB) (PF)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.15	0.68	2.15	0.015	0.007	0.05

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	260
-	-	650°C(1202°F) Tempering	240
-	-	900°C(1652°F), O.Q	380

## Approval

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size 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	55~90	90~140	140~190	190~240	220~300
V-up	50~80	80~130	110~170	-	-