

Applications

For intermetallic abrasion and light soil abrasion. Hardfacing of idlers and truck links.

Characteristics on Usage

S-500B.B is an electrode designed for putting prime importance on hardness, but not neglecting toughness. Machining is difficult. The welds become passably mild with gradual cooling after welding. It is suitable for heavy duty intermetallic abrasion and light impact abrasion.

Notes on Usage

- ① Preheat at 150°C(302°F) and 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 Pay attention to blow hole at the arc starting.
- ④ Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.

Welding Position

Current



1G 2F
(PA) (PB)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.41	0.75	1.73	0.018	0.007	1.60	0.86

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	520
300 (572)	-	-	480

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