

## Applications

For soil abrasion. Hardfacing of cutting knives and casings.

## Characteristics on Usage

S-700B.B is an electrode depositing weld metal of martensite which is harder than that of S-600B.B. This electrode, all-weld metal of very hard martensite structure containing small quantity of austenite structure. Machining is impossible "as welded". It is mostly suitable for soil abrasion.

## Notes on Usage

- ① Preheat at 150°C(302°F) or more than that in general.
- ② Postheat at about 600°C(1112°F), if possible.
- ③ In case of multi-layer build-up welding or welding base metal of hardening property, underlay with low hydrogen type carbon steel electrodes.
- 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
0.56	1.26	1.67	0.029	0.011	4.06	1.84

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	610
300 (572)	-	-	580

## 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