

**Description**

- Covering is low hydrogen type for hardfacing of metal mould, thermal cutting off machine, forging moule, dotting punch, compression tap, impact tap and axis of rotation.
- The microstructure of deposited weld metal has mertsensite.
- Preheat at 200-300°C and postheat treat at 500-600°C, if possible.
- Keep up interpass temperature same as preheating temperature, if possible.
- Redry the electrode at 300-400°C for 1-2 hours prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	V	W
0.25	0.59	0.95	0.018	0.013	0.02	2.5	1.0	4.2

**Typical mechanical properties of all-weld metal**

Conditions	As welded			Heat treated(Air cooling)		
	Continuous surfacing	Preheat and interpass temp. 150°C	350°C X 2Hr	550°C X 2Hr	650°C X 2Hr	780°C X 2Hr
HV	520-570	560-600	570-620	640-690	530-580	280-320
HRC	51-54	53-55	54-56	57-60	51-54	27-32
HS	67-71	71-74	71-75	77-81	67-72	40-45

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	400	400	400
Amp. (A)	F	90-130	100-150	120-170	150-200