

Classifications

EN ISO 14700:2005 : T Fe7 JIS Z 3326 : YF4A-G-350

Description

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include tractor rollers, trunnions, crane wheels, track rails
- In order to minimize cracking, should obey the preheat and interpass temperature

Welding positions



Polarity & shielding gas

- Mix: Ar+2% O₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr	Ni
Mix	0.05	0.25	0.30	0.014	0.009	12.00	4.20

Typical mechanical properties of all-weld metal

	Hv	Typical value HRC	Hs	Interpass Temp (°C)	Remarks
Example (Mix)	350~450	35~45	47~59	150	As weld

* Composition and hardness depend upon dilution. Single layer deposit hardness depend upon base metal and/or build-up material.

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	10, 15, 20		