

Applications

For impact scraping abrasion. Crusher hammers, crusher jaws, crusher rolls and conveyor buckets.

Characteristics on Usage

Good covering property and removability of the slag. Low spatter loss.

Beautiful bead appearance.

Very high impact resistance. Good resistance to abrasion. Cutting property is impossible.

Notes on Usage

- ① Cool the weld metal with water during welding.
- ② Austenite type stainless steel electrodes should be used for under-laying on the base metal other than 13% Mn steel.
- ③ When the base metal of 13% Mn steel is hardened, cut-off the hardened zone before welding.
- 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
0.38	0.06	14.5	0.030	0.003	1.16	1.57

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Postheat	Heat Treatment.	Hardness(HB)
R.T	-	-	220
	-	After work hardening	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)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350(14)	400 (16)	400 (16)	450 (18)
F	90~150	140~190	190~240	220~300