S-240A.R

TYPE : Rutile

JIS Z3251 DF2A-250-R

Applications

Hardfacing of rollers, gears, crane wheels and abrasive parts of various machines.

Characteristics on Usage

Very stable arc. Good covering property and excellent removability of slag.
Beautiful bead finish and low spatter loss.
Loss abrasive resistance, medium impact resistance and fairly good cutting property.

Notes on Usage

① Hardfacing large size cast steel and forging, low alloy steel and high carbon steel requires preheating at 150℃(302℉) and more than that.
② The groove repairing is prone to slag inclusion. Adjust the holding angle of the electrodes.
③ Dry the electrodes at 70~100℃(158~212℉) for 60 minutes before use.

Welding Position

1G (PA) 2F (PB) 3G (PF)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.10	0.37	0.49	0.017	0.009	0.89

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp.℃(℉)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	240
-	-	650℃(1202℉) Tempering	200
-	-	900℃(1652℉), O.Q	330

Approval

I Packing

Packet 5 ㎏ (11 lbs)
Carton 5 ㎏ (11 lbs)×4 : 20㎏(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	50~85	80~130	130~180	180~240	210~280
V-up	40~70	70~120	120~160	-	-