

Applications

For intermetallic heavy abrasion and soil abrasion. Hardfacing of lower rollers and bucket edges.

Characteristics on Usage

S-600B.B is an electrode depositing all-weld metal of typical martensite structure. It is suitable for soil abrasion. The weld softens with the heat.

Notes on Usage

- ① Preheat at 150°C(302°F) or more than that in general.
- ② In case of multi-layer build-up welding or welding base metal of hardening property, underlay with low hydrogen type carbon steel electrodes.
- ③ Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.

Welding Position



1G 2F
(PA) (PB)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.52	1.10	1.61	0.022	0.009	3.90	1.34

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp.°C(°F)	Postheat	Heat Treatment.	Hardness(HB)
150 (302)	-	-	540
300 (572)	-	-	500
600 (1112)	-	-	450

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