

Buffer layer and welding repairs

GH300

JIS Z 3251 DF2A-300B

Product Features:

- Weld metal typical hardness approximately HRC31.
- High welding performance, low spatter loss and good bead appearance.
- Good cutting workability.

Applications:

- Suitable for repairing welding on 1st buffer layer of gear, shaft, bulldozer's roller/guide roller, rail and wheel, etc.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo	Fe
0.07	0.46	0.99	1.71	0.23	Bal.

Typical hardness of weld metal

As welded HRC	950°C water quenching HRC
31	42.5

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/400	4.8/350	5.0/450
Flat position	100~140	140~190	170~220	180~230
Vertical / overhead position	90~120	120~170	----	----

Note:

- 300~350°C x 1 hr baking prior to use.
- Keep short arc length while welding.
- 150°C preheating temperature on base metal before welding.

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