

Buffer layer and welding repairs

GH300R

JIS Z 3251 DF2A-300R

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
0.13	0.60	1.25	1.10	0.03	Bal.

Typical hardness of weld metal

As welded HRC	950°C quenching HRC
31	42.5

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	70~100	100~140	140~190	180~230	240~300

Note:

- 100~120°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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