

## GH300

JIS Z 3251 DF2A-300B

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**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
0.07	0.46	0.99	1.71	0.23

**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	5.0/450
Flat position	100~140	140~190	180~230
Vertical / overhead position	90~120	120~170	—

- ◎ Note: 1. 300~350°C x 1 hr baking prior to use.  
 2. Keep short arc length while welding.  
 3. 150°C preheating temperature on base metal before welding.

## 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
0.13	0.60	1.25	1.10	0.03

**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
Flat position	50~80	100~140	140~190	180~230

- ◎ Note: 1. 100~120°C x 1 hr baking prior to use.  
 2. Keep short arc length while welding.  
 3. 150°C preheating temperature on base metal before welding.