

GH350R

JIS Z 3251 DF2A-350R

Product Features:

- Weld metal typical hardness approximately HRC35.
- High welding performance, low spatter loss and good bead appearance.
- Good cutting workability.

Applications:

- Suitable for hardfacing repair welding of machinery; carbon steel, cast iron and hardenable alloy steel repair and fabrication welding.

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

C	Si	Mn	Cr	Mo
0.11	0.37	0.86	2.37	0.63

Typical hardness of weld metal

As welded HRC	layers
35.7	3

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.

GH450

JIS Z 3251 DF2A-450B

Product Features:

- Weld metal typical hardness approximately HRC47.
- Martensite structure self-hardening weld metal.
- Good resistance to moderate impact and abrasion conditions.

Applications:

- Suitable for buildup, hardfacing and repair welding of metal to metal abrasion worn out machine parts on quarry machine, bulldozer chain gear, shovel bucket, caterpillar band, shovels teeth, and cutters, etc.

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

C	Si	Mn	Cr	Mo
0.27	0.88	1.09	2.36	0.22

Typical hardness of weld metal

As welded HRC	600°C Tempering HRC
46.6	36.5

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

- ◎ Note: 1. 300~350°C x 1 hr baking prior to use.
2. Keep short arc length while welding.
3. Recommend to apply low hydrogen electrode on buffer layer for high hardenability base metal or multiple passes welding.

GH450R

JIS Z 3251 DF2B-450R

Product Features:

- Weld metal typical hardness approximately HRC47.
- High welding performance, less spatter loss and good bead appearance.
- Martensite structure weld metal to get good abrasion resistance.

Applications:

- Suitable for buildup, hardfacing and repair welding of metal to metal abrasion worn out machine parts on quarry machine, bulldozer chain gear, shovel bucket, caterpillar band, shovels teeth, and cutters, etc.

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

C	Si	Mn	Cr	Mo
0.35	0.26	0.62	3.50	0.52

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
47	36.3

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. Recommend to apply low hydrogen electrode on buffer layer for high hardenability base metal or multiple passes welding.

GH600R

JIS Z 3251 DF3B-600R

Product Features:

- Titanium oxide type covered electrode, good for metal-to-metal abrasion resistance.
- High welding performance, less spatter loss and good bead appearance .
- Weld metal typical hardness approximately HRC55.
- Martensite structure weld metal to get good abrasion resistance.

Applications:

- Suitable for build up and repair welding of high wear resistance and none-post machining required worn out machine parts on quarry machine, shovels teeth, crusher, fork lift, dredge, stone agitator, pump blade, screw conveyer, etc.

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

C	Si	Mn	Cr	Mo
0.34	0.34	0.62	3.88	0.74

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
55.7	44.5

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. Surface dirt such as grease or rust on groove side or repair area to be completely removed before welding.

GH600

JIS Z 3251 DF3C-600B

Product Features:

- Martensite structure self-hardening weld metal.
- Weld metal typical hardness approximately HRC55.

Applications:

- Suitable for build up and repair welding of high wear resistance and none-post machining required worn out machine parts on quarry machine, shovels teeth, crusher, fork lift, dredge, stone agitator, pump blade, screw conveyer, etc.

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

C	Si	Mn	Cr	Mo
0.74	0.89	1.24	5.17	0.02

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
55.6	44.5

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

- © Note: 1. 300~350°C x 1 hr baking prior to use.
2. Surface dirt such as grease or rust on groove side or repair area to be completely removed before welding.