

S-500B.B

Type : Basic

Conformances

JIS Z3251 DF2B-500-B

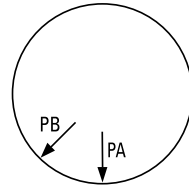
Applications

- Hardfacing of rollers, gears, crane wheels and abrasive parts

Features

- Under-lay with low hydrogen type carbon steel electrode
- Preheat at more than 150°C(302°F)
- Machining difficult

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

| Diameter mm (in) | Length mm (in) | Standard | |
|---------------------|-------------------|----------------------|-----------------------|
| | | packet 5kg(11lbs) | carton 20kg(44lbs) |
| 2.6 (3/32) | 350 (14) | | √ |
| 3.2 (1/8) | 350 (14) | | √ |
| 4.0 (5/32) | 400 (16) | | √ |
| 5.0 (3/16) | 400 (16) | | √ |
| 6.0 (15/64) | 450 (18) | | √ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Cr | Mo |
|------|------|------|-------|-------|------|------|
| 0.41 | 0.75 | 1.73 | 0.018 | 0.007 | 1.60 | 0.86 |

Typical Mechanical Properties of All-Weld Metal

| Preheat & Interpass Temp.°C(°F) | Postheat | Heat Treatment | Hardness (HB) |
|------------------------------------|----------|----------------|------------------|
| 150 (302) | - | - | 520 |
| 300 (572) | - | - | 480 |

Typical Welding Parameters / Amp.(A)

| Diameter 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 & HF | 55-90 | 90-140 | 140-190 | 190-240 | 220-300 |