HYUNDAI WELDING

Rev. 00

S-260A.B

COVERED ARC WELDING ELECTRODE
FOR HARDFACING OF INTERMETALLIC ABRASION

HYUNDAI WELDING CO., LTD.

S-260A.B

❖ Specification

JIS Z3251 DF2A-300-B

❖ Applications

For intermetallic light abrasion, hardfacing and repairing of worn parts of shafts, gears, wheels, etc.

❖ Characteristics on Usage

Stable arc. Beautiful bead appearance. Good flow and easy removal of the slag. High abrasion resistance and impact resistance.

❖ Note on Usage

1. Preheating is unnecessary, in general, in case of multi-layer welding of low alloy steel and high carbon steel, preheat at about 150℃(302°F).
2. Adopt back step method or strike arc on al small steel plate prepared for this particular purpose for preventing blow hole at the arc starting.
3. Dry the electrodes at 350~400℃(662~752°F) for 60 minutes before use.

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Mechanical Properties & Chemical Compositions of all-Weld Metal

❖ Typical Chemical Composition of All-weld Metal(wt%)

size Mm(in)	Chemical Composition (%)					
	C	Si	Mn	P	S	Cr
4.0 X 400 (5/32 X 16)	0.15	0.68	2.15	0.015	0.007	0.05

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. ℃(°F)	Hea Treatment.	Hardness (HB)
150(302)	-	260
-	650℃(1202°F) Tempering	240
-	850℃(1562°F), O.Q	380

❖Available sizes and Recommended Current

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)
Recommended current range (AC or DC+)	Flat (1G-PA)	55 ~90	90 ~140	140 ~190	190 ~240	220 ~300
	Vertical Up	50 ~80	80 ~130	110 ~170	-	-