

Covered Electrodes

KM-350

For hardfacing (Hv 350)

Classifications

KS D 7035 : DF2B-350-B
JIS Z 3251 : DF2B-350-B

Description

- Covering is low hydrogen type for hardfacing of fans, upper rollers, shafts and sprockets.
- Machining is possible in general.
- Hardness increases by quenching after machining.
- Suitable for intermetallic abrasion and moderate impact abrasion.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.36	0.65	0.74	0.014	0.011	0.02	2.00	0.01	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded	Heat treated	
	Interpass temp. 150°C	900°C oil quenching	650°C stress relief
HV	356	440	300
HRC	36.1	44.5	29.8
HS	49	59	42

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F	90~130	140~180	190~240	220~300