

S-500B.B

Type : Basic

Conformances

JIS Z3251 DF2B-500-B

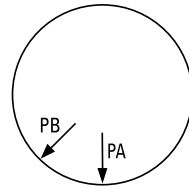
Applications

- 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