

S-240A.R

COVERED ARC WELDING ELECTRODE
FOR HARDFACING OF INTERMETALLIC ABRASION



❖ Specification

JIS Z3251

DF2A-250-R

❖ Applications

Hardfacing of rollers, gears, crane wheels and abrasive parts of various machines.

❖ Characteristics on Usage

Very stable arc. Good covering property and excellent removability of slag. Beautiful bead finish and low spatter loss. Loss abrasive resistance, medium impact resistance and fairly good cutting property.

❖ Note on Usage

1. Hardfacing large size cast steel and forging, low alloy steel and high carbon steel requires preheating at 150°C(302°F) and more than that.
2. The groove repairing is prone to slag inclusion. Adjust the holding angle of the electrodes.
3. Dry the electrodes at 70~100°C(158~212°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)	0.10	0.37	0.49	0.017	0.009	0.89

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hea Treatment.	Hardness (HB)
150(302)	-	240
-	650°C(1202°F) Tempering	200
-	900°C(1652°F), O.Q	330

❖ 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)	50 ~85	80 ~130	130 ~180	180 ~240	210 ~280
	Vertical Up	40 ~70	70 ~120	120 ~160	-	-

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