



**HARDFACING STICK WELDING**  
**PRODUCT (SMAW)**  
**D400-B**

**FEATURES**

- \*MIXED METAL STRUCTURE OF AUSTENITE AND MARTENSITE
- \*UNDER-LAY WITH LOW HYDROGEN TYPE CARBON STEEL ELECTRODE
- \*PREHEAT AT MORE THAN 150°C (302°F)

**APPLICATION**

- \*HARDFACING OF ROLLER, GEARS, CRANE WHEELS, AND ABRASIVE PARTS

**CLASSIFICATION**

- \*JIS Z3251 DF2A-450B

**CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.26	0.82	1.44	0.019	0.01	1.64		0

**WELDING PARAMETERS**

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	300	350
CURRENT (amps)	70-100	100-150

**CURRENT**

- \*AC or DC +/-

**HARDNESS**

**HB (390-470) HRC ( 42-50)**  
**(Tempering 650C-850C)**