



M-90 D450-B

FEATURES

- *UNDER-LAY WITH LOW HYDROGEN TYPE CARBON STEEL ELECTRODE
- *PREHEAT AT MORE THAN 150° C (302°F)
- *SUITABLE FOR SOIL ABRASION
- *MARTENSITE STRUCTURE (ALL-WELD METAL)

APPLICATION

- *HARDFACING OF ROLLERS, GEARS, CRANE WHEELS, AND ABRASIVE PARTS

CLASSIFICATION

JIS Z3251 DF2B-450-B

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.30	1.06	0.56	0.019	0.01	1.64		0.63

WELDING PARAMETERS

DIAMETER (mm)	3.2	4.0
LENGTH (mm)	350	350
CURRENT (amps)	90-130	120-160

CURRENT

*AC or DC +/-

HARDNESS

HB (350-400) HRC (37-42)