



M-90 D600-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, GEAR, CRANE WHEELS, AND ABRASIVE PARTS

CLASSIFICATION

*JIS Z3251 DF2B-600-B

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.52	1.10	1.61	0.022	0.009	3.90		1.34

WELDING PARAMETERS

DIAMETER (mm)	3.2	4.0
LENGTH (mm)	350	350
CURRENT (amps)	100-150	140-200

CURRENT

*AC or DC +-

HARDNESS

HB (580-610) HRC (56-59)