

Classifications

KS D 7035-2002 DF3C-700-B
 JIS Z 3251-2000 DF3C-700-B

Description

- Covering is low hydrogen type for hardfacing of impellers, pump casings.
- The deposited weld metal has an extremely hard martensite structure.
- Machining is impossible as welded.
- Preheat at 200°C and over.
- Postheat treat at about 600°C immediately after welding.
- Redry the electrode at 300–400°C for 1–2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.47	1.45	1.51	0.017	0.012	0.03	4.1	0.02	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded		Heat treated 600°C stress relief
	Interpass temp. 150°C	Interpass temp. 200°C	
HV	723	810	535
HRC	61.1	64.4	51.4
HS	83	89	69

Sizes available and recommended currents (AC or DC+)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F	90~130	140~170	190~240	220~300