

S-240A.R

Type : Rutile

Conformances

JIS Z3251 DF2A-250-R

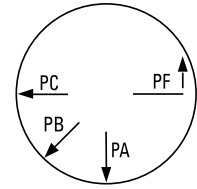
Applications

- Hardfacing of rollers, gears, crane wheels and abrasive parts

Features

- Light abrasive resistance, impact resistance
- Good cutting properties
- Stable arc
- Easy to remove slag
- Low spatter
- Good bead appearance

Welding Position



Current

AC or DC ±

Redrying Conditions

100°C (212°F) X 1hr

Diameter / Packaging

Diameter	Length	Standard	
		packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)		✓
3.2 (1/8)	350 (14)		✓
4.0 (5/32)	400 (16)		✓
5.0 (3/16)	400 (16)		✓
6.0 (15/64)	450 (18)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
0.10	0.37	0.49	0.017	0.009	0.89

Typical Mechanical Properties of All-Weld Metal

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

Typical Welding Parameters / Amp.(A)

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)
F & HF	50-85	80-130	130-180	180-240	210-280
V-up, OH	45-70	70-120	120-160	-	-

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX