HYUNDAI WELDING

Rev. 00

S-711

COVERED ARC WELDING ELECTRODE
FOR HARDFACING OF ABRASION

HYUNDAI WELDING CO., LTD.

S-711

❖ Specification

JIS Z3251 DFCrA-600-BR

❖ Applications

Mills to crush clinker in cement industry, screws of crushing grains in oil industry.

❖ Characteristics on Usage

S-711 is highly resistant to abrasion without impacts. S-711 is an electrode depositing wild metal of austenite structure which is harder than that of S-700B.B

This electrode deposits weld metal of austenite structure containing Cr-Carbide.

Machining is impossible 'as-welded'

❖ Note on Usage

1. Preheat at 150℃(302°F) or more than that in general.
2. Weave during welding in the width of approx. 50mm.
3. Avoid excessive dilution.
4. Dry the electrodes at 350~400℃(662~752°F) for 60 minutes before use.

S-711

Mechanical Properties & Chemical Compositions of all-Weld Metal

❖ Typical Chemical Composition of All-weld Metal(wt%)

size Mm(in)	Chemical Composition (%)					
	C	Si	Mn	P	S	Cr
4.0 X 400 (5/32 X 16)	3.47	0.90	1.11	0.018	0.014	33.9

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. ℃(°F)	Hea Treatment.	Hardness (HB)
≥300(572)	-	610

❖Available sizes and Recommended Current

Diameter, mm(in)		3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length, mm(in)		400(16)	400(16)	400(16)
Recommended current range (AC or DC+)	Flat (1G-PA)	110 ~160	160 ~200	200 ~260