

SMAW

For Hard Surfacing

HARDFACING 700R

CLASSIFICATION : JIS Z3251 DF2B-600-R

WELDING POSITIONS : 

- Wear Resistant, High Carbon Martensitic Steel Deposit
- Rutile Type, AC / DC Hard Surfacing Electrode
- For a Wide range Of General Hard Surfacing Applications, Such As Points, Tyres, Lips, Blades and Augers, Etc.

DESCRIPTION AND APPLICATIONS

HARDFACING 700R is a smooth running, AC/DC electrode which deposits an air hardening martensitic steel alloy. HARDFACING 700R deposits one of the hardest steel alloys available and is free from relief checks. It is suitable for a wide range of applications including the surfacing of post hole augers, agricultural points, shares and tyres, grader and cultivator blades and other components subject to fatigue or flexing during service.

DEPOSIT PROPERTIES

HARDFACING 700R deposits an air hardening steel alloy which can be readily hot forged and offers good resistance to all types of abrasion under low to moderate impact conditions. In the "as welded" condition HARDFACING 700R weld metal cannot be machined without prior heat treatment.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Mo	V	Fe
0.08	0.41	0.5	8.0	0.25	0.45	Bal

DEPOSIT HARDNESS

SINGLE-LAYER ONTO MILD STEEL •
MULTI-LAYER

TYPICAL HARDNESS 53 - 56 HRC
TYPICAL HARDNESS 55 - 60 HRC

- Single layer deposit hardness may vary depending on base metal type and degree of dilution.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)	
			PKT	CTN
3.2	400	90 - 130	5	20
4.0	400	140 - 180	5	20
5.0	400	160 - 280	5	20

- Recommended for DC + or AC (minimum 45 OCV) operation

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