

**Classifications**

EN ISO 14700:2005 : T Fe1 JIS Z 3326 : YF2A-C-350

**Description**

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include transfer rollers and idlers, crane wheels
- In order to minimize cracking, should obey the preheat and interpass temperature

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	P	S	Cr	Mo
CO <sub>2</sub>	0.12	0.45	1.37	0.015	0.011	1.30	0.20

**Typical mechanical properties of all-weld metal**

	Hv	Typical value HRC	Hs	Interpass Temp(°C)	Remarks
Example (CO <sub>2</sub> )	300~400	29~40	42~55	150	As weld

× Composition and hardness depend upon dilution. Single layer deposit hardness depend upon base metal and/or build-up material.

**Package**

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	10, 15, 20		