

For Hard-facing

Conformances

JIS Z3326 YF3B-C-600

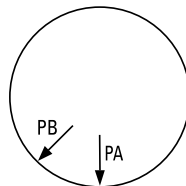
Applications

• Rollers, shear blades, screw conveyor etc.

Features

- Flat and horizontal fillet position welding
- Suitable for abrasion parts

Welding Position



Current

DC +

Shielding Gas

100% CO₂ / FCAW process

Diameter / Packaging

Diameter mm (in)	Spool 15kg (33lbs)
1.2 (0.045)	✓
1.4 (0.052)	✓
1.6 (1/16)	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Mo	V	W	Others
0.35	0.8	1.6	4.2	0.6	-	-	-

Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)
620~680

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC +					
100% C ₆ O	20 (4/5)	9.8 (385)	230	25~27	4.4 (9.7)
		12.5 (492)	260	27~29	5.3 (11.6)
		14.2 (559)	300	29~31	6.1 (13.4)
1.6mm (1/16 in) DC +					
100% C ₆ O	20 (4/5)	5.8 (228)	260	27~29	4.9 (10.8)
		7.9 (311)	300	28~30	5.7 (12.5)
		9.7 (381)	330	29~31	7.3 (16.0)