

**Description**

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include crane wheels, blower blades, bucket lips, dredge parts etc
- 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	W
CO <sub>2</sub>	0.40	3.20	0.60	0.012	0.010	7.00	0.80

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

	Hv	Typical value HRC	Hs	Interpass Temp (°C)	Remarks
Example (CO <sub>2</sub> )	600~800	55~64	74~88	200	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		