

Covered Electrode for Anti Erosion and Anti Intermetallic Wear

M H - 6 0 0

- Standard JIS DF2B-B
- Covering Low Hydrogen Type
- Tip Color Vermilion

- Application
 Overlayin
 Hardfacin

- Features

1. MH-600 is the air hardening type covered electrode. The deposited metal is formed by mixture of austenite and martensite as a result it shows excellent toughness and crack resistance.
2. The deposited metal also shows excellent heat resistance and impact resistance. Hence MH-600 is also suitable for hardfacing on the mold which requires durability.

- Welding Procedures

1. In general, preheating and interpass temperature at more than 150°C are required.
2. In case of multilayer welding or overlaying on the hardenable base metal, underlaying by low hydrogen type welding consumables for high tensile strength steel is effective in preventing crack.
3. Slow cooling is required after welding.
4. The electrode should be re-dried for 30~60 minutes at over 300°C before use.

- Typical Chemical Component of the Deposited Metal (%)

C	Si	Mn	Other Elements
0.45	0.70	2.35	2.00~3.00

- Typical Hardness of the Deposited Metal as welded

Condition	HV	HRC	HS
Continuous Overlaying	530~570	51~54	68~72
Interpass Temp. at 150°C	550~600	52~55	70~74

- Appropriate Welding Current (AC or DCEP)

Diameter (mm)	3.2	4.0
Length (mm)	350	400
Current (A)	70~110	100~150
Min. Quantity (Kg)	5.0	5.0

Equivalent to wire for MAG welding: EDS-600
 Equivalent to electrode for TIG welding: EDS-600T