

# S-700B.B

AS/NZS 2576: 1855-A4

TYPE : Basic

## Applications

For soil abrasion. Hardfacing of cutting knives and casings.

## Characteristics on Usage

S-700B.B electrode deposits all-weld metal of very hard martensite structure, containing small quantity of retained austenite. Machining is not possible in as-deposited condition. It has widespread use in applications involving soil abrasion.

## Notes on Usage

- 1) Preheat at 150 °C or more
- 2) In case of multi-layer build-up or building up base metal with hardening property, underlay with low hydrogen type carbon steel electrodes.
- 3) Dry the electrodes at 350~400 °C for 60 minutes before use.

## Surfacing Position

## Current



D/H Hor.

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.56	1.26	1.67	0.029	0.011	4.06	1.84

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C	Postheat	Heat Treatment.	Hardness(HB)
150	-	-	610
300	-	-	580

## Approval

## I Packing

Packet 5kg  
Carton 5kg x 4 = 20kg

## Sizes Available and Recommended Currents (Amp.)

Size mm	3.2	4.0
Length mm	350	400
Flat (A):	90~140	140~190

Diam.	5kg Pack
3.2mm	HKS-700B32
4.0mm	HKS-700B40

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