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☞ JIS Z 3251 : 2000

Covered electrodes for hardfacing

ICS 25.160.20

Descriptors : covered electrodes, steels, welding rods, arc welding

Reference number : JIS Z 3251 : 2000 (E)



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Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at the Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law. Consequently **JIS Z 3251 : 1991** is replaced with **JIS Z 3251 : 2000**.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

This revision employs **JIS Z 3200 : 1999** *Welding consumables—Technical delivery conditions for welding filler metals—Type of product, dimensions, tolerances and marking* as the normative reference.

Date of Establishment: 1960-01-01

Date of Revision: 2000-11-20

Date of Public Notice in Official Gazette: 2000-11-20

Investigated by: Japanese Industrial Standards Committee
Divisional Council on Welding

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In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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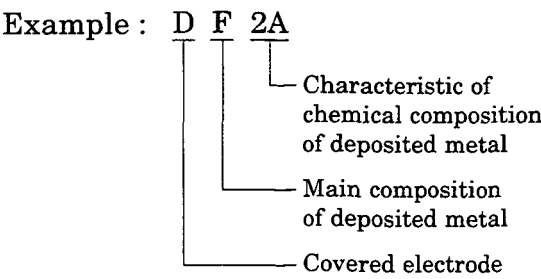
Covered electrodes for hardfacing

- 1 **Scope** This Japanese Industrial Standard specifies the covered electrodes for hardfacing on the surface of iron and steel (hereafter referred to as “electrodes”).
- 2 **Normative references** The standards listed in Attached Table 1 contain provisions which, through reference in this Standard, constitute provisions of this Standard. The most recent editions of the standards (including amendments) shall be applied.
- 3 **Classification** The electrodes shall be classified by chemical composition of deposited metal, system of coating flux and welding position as in Table 1.

Table 1 Classification of electrodes

Classification	System of coating flux	Welding position
DF2A	B, R, BR	F, V, H
DF2B	B, R, BR	F
DF3B	B	F, V, H
DF3C	B	F
DF4A	B	F
DF4B	B	F
DF5A	B, BR	F
DF5B	B, BR	F
DFMA	B	F
DFMB	B	F
DFME	B	F
DFCrA	B, R, BR	F
DFWA	S	F
DCoCrA	BR	F
DCoCrB	BR	F
DCoCrC	BR	F
DCoCrD	BR	F

Remarks 1 The symbols for classification shall be given in the following example:



2 The symbols for system of coating fluxes mean the following:

B: basic, R: high titanium oxide,
BR: lime titania, S: special

3 The symbols for welding positions mean the following:

F: flat, V: vertical, H: horizontal

Among the welding positions given in Table 1, V and H, as a rule do not apply to electrodes with diameters exceeding 5.0 mm.

4 Quality

4.1 Covering The covering shall be in accordance with 3 of JIS Z 3200.

4.2 Chemical composition The chemical composition of deposited metal shall conform to Table 2 when tested in accordance with the methods specified in 7.2.