



CHUUA ELECTRODE

For hardfacing.

Type of covering	Brand name	Size (mm)	Equivalent specification	Welding position	Type of current	Typical chemical composition of all-weld-metal(%)						Typical hardness of all-weld-metal (HV)	Main use
						C	Si	Mn	Ni	Mo	Other elements		
High titania type	BK-250R	3.2-6.0	JIS DF2A-250-R	F,V,H	AC or DC(+)	0.12	0.38	1.11	—	—	—	250-270	For metal-to-metal wear. Hardfacing of gears and wheels.
	BK-350R	3.2-6.0	JIS DF2A-350-R	F,V,H	AC or DC(+)	0.17	0.41	0.86	2.74	—	—	340-360	For metal-to-metal wear. Hardfacing of gears and shafts.
	BK-300R	3.2-6.0	JIS DF2A-300-R	F,V,H	AC or DC(+)	0.22	0.38	0.53	2.90	—	—	300-320	For metal-to-metal wear. Hardfacing of shafts, rollers and similars.
Low hydrogen type	BK-250B	3.2-6.0	JIS DF2A-250-B	F,V,H	AC or DC(+)	0.10	0.52	1.86	—	—	—	250-280	For metal-to-metal wear. Hardfacing and repairing of worn parts such as shafts, gears, wheels, etc.
	BK-300B	3.2-6.0	JIS DF2A-300-B	F,V,H	AC or DC(+)	0.21	0.58	1.62	0.73	—	—	310-280	For metal-to-metal wear. Hardfacing of couplings, rails and gear parts, etc.
	BK-350B	3.2-6.0	JIS DF2B-350-B	F	AC or DC(+)	0.37	0.63	0.72	1.98	—	—	340-360	For metal-to-metal wear. Hardfacing of rollers, shafts and sprockets, etc.
	BK-5	3.2-6.0	JIS DF2B-450-B	F	AC or DC(+)	0.41	0.92	1.93	3.86	—	—	450-510	Hardfacing of rollers, sprockets, screw conveyors and bulldozer blades, etc.
	BK-6	3.2-6.0	JIS DF2B-700-B	F	AC or DC(+)	0.52	0.80	1.86	4.75	—	—	600-630	For scratching abrasion. Hardfacing of mixers, cutter knives and dredgers, etc.
	BK-8	3.2-6.0	JIS DF3C-700-B	F	AC or DC(+)	1.21	0.80	2.10	6.82	1.80	—	680-740	For scratching abrasion. Hardfacing of pump casings, impellers and buckets,etc.
	HMN	3.2-6.0	JIS DFMA-250-B	F	AC or DC(+)	0.75	0.25	14.58	—	—	—	230-250	For impact and abrasion resistance. Hardfacing of crushers, high manganese steel rails, bucket lip and shovel teeth.
	BK-13CR	3.2-6.0	JIS DF4B-500-B	F	AC or DC(+)	0.28	0.60	0.58	13.15	1.20	—	540-600	For wear and corrosion resistance at elevated temperature. Hardfacing of cuttion tools, shearing blades and similars.
	KSW-R	2.6-5.0	—	F	AC or DC(+)	0.28	0.35	1.42	17.58	4.35	V,Ni, W	300-320	For impact and wear resistance at elevated temperature. Hardfacing of cutting tools, forming dies and shearing dies, etc.
Lime titania type	MCS	3.2-6.0	—	F	AC or DC(+)	0.38	0.55	13.05	14.25	1.75	Ni, W	310-330	For wear resistance at elevated temperature. Hardfacing of ingot tongs, broaches and similars.
	BK-800	3.2-6.0	—	F	AC or DC(+)	0.46	0.31	0.40	8.55	1.25	W	600-640	Hardfacing of press moulds, forged metal moulds, tool steels and hardened parts by quenching.
	BK-600	2.6-5.0	JIS DF3B-600-BR	F	AC or DC(+)	0.52	0.10	0.52	6.12	1.75	V	580-620	Hardfacing of clutch cams, forming dies and forged metal moulds.
Special type	BK-9	3.2-6.0	—	F	AC or DC(+)	2.92	0.15	0.60	—	5.85	W	840-950	For severe abrasion. Hardfacing of cutter knives, shovel teeth, cement mixers, fans, etc.