KH-50N-1

Type of coating: Lime titania type

Classification

AWS	A5.13	—
JIS	Z3251	DF2B-450-BR
EN	14700	E Fe8
GB	T 984	—

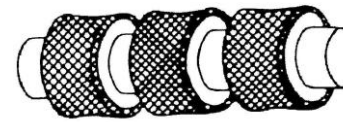
Applications and Features

(1) Weld metal is martensite structure with 13%Cr.

(2) It provides stable hardness, excellent corrosion resistance and acid resistance.

(3) KH-50N-1 has better thermal fatigue and crack resistance than KH-50 due to the addition of Ni and Mo. The abrasion resistance at high temperature is outstanding.

(4) It is suitable for repairing molds, steel wheels, agitator blades and hot rolling rollers.



Hot rolling roller

Welding Instruction

(1) Dry the electrodes at 200-250°C for 30-60 minutes before use.

(2) Clean up the contaminations on the work piece. Keep arc as short as possible.

(3) Preheat temperature should be above 150°C for repairing low alloy steel or medium/high carbon steel.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	Ni	Mo
0.180	0.23	0.70	13.10	1.21	1.28

Typical Hardness of Weld Metal

Condition \ Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. ≤150°C	530	51	69

Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350	6.0x400
Amp	70~120	100~170	160~220	200~280