

Stick Electrode for Hardfacing

KH-50N-4

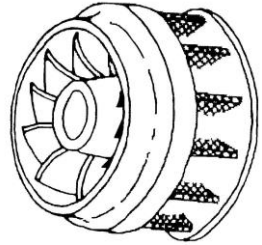
Classification

AWS	A5.13	—
JIS	Z3251	DF4B-450-BR
EN	14700	E Fe7
GB	T 984	—

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is martensite structure with 13%Cr.
- (2) It provides excellent hardness, toughness, corrosion, heat and crack resistance.
- (3) It is suitable for repairing turbines impeller, heat exchanger brackets, valve brackets and molds.



Turbine impeller

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.
- (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
0.080	0.31	0.60	12.78	3.70	1.20

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. ≤150°C		452	45	60

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