

Stick Electrode for Hardfacing

KH-60-B

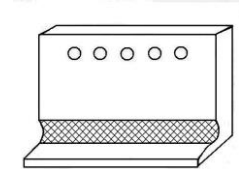
Classification

AWS	A5.13	—
JIS	Z3251	DF3C-600-B
EN	14700	E Fe4
GB	T 984	—

Type of coating: Low hydrogen type

Applications and Features

- (1) Weld metal is martensite structure.
- (2) It is unable to be machined and cut.
- (3) It is used in medium impact and high abrasion conditions.
- (4) It is suitable for repairing spiral conveyor, bulldozer and cutter.



Bulldozer blade

Welding Instruction

- (1) Dry the electrodes at 300-350°C for 30-60 minutes before use.
- (2) Clean up the contaminations on the work piece. Keep the arc as short as possible.
- (3) Take the back-step method to prevent porosity at the arc starting.
- (4) Preheat and the Interpass temperature should be $\geq 200^{\circ}\text{C}$.
- (5) Use high tensile strength low hydrogen electrode for the buffer layer in multi-layer build-up.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	Ni
0.700	1.00	1.00	6.50	1.35

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)		Rockwell's hardness (HRC)		Shore's hardness (HS)	
		200	300	400	500	600	700
As-welded	Interpass temp. $\leq 150^{\circ}\text{C}$	660		58		79	
	Continuous build-up	630		57		75	
Work-hardened		630		56		75	
High Temp.	Temperature ($^{\circ}\text{C}$)	200	300	400	500	600	700
	Vicker's hardness	530	490	440	430	200	100

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