

KH-61-BR

Classification

AWS	A5.13	—
JIS	Z3251	DF3B-600-BR
EN	14700	E Fe4
GB	T 984	EDPCrMo-A5-03

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal contains the carbide precipitates of Cr, Mo, and V.
- (2) It is unable to be machined and cut.
- (3) It provides excellent weldability, heat resistance and impact toughness.
- (4) It is suitable for repairing forging molds.

Welding Instruction

- (1) Dry the electrodes at 200-250°C for 30-60 minutes before use.
- (2) Preheat temperature should be $\geq 200^{\circ}\text{C}$ and PWHT should be 600°C .
- (3) Use high tensile strength low hydrogen electrode for the buffer layer in multi-layer build-up and base metal with high hardenability.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	Mo	V
0.470	0.28	0.38	5.93	1.33	0.48

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 150^{\circ}\text{C}$		670	59	79
Continuous build-up		650	57	77

Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350	6.0x400
Amp	80~120	120~170	160~210	200~280