

Stick Electrode for Hardfacing

KH-61-B

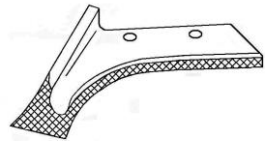
Classification

AWS	A5.13	—
JIS	Z3251	DF3C-600-B
EN	14700	E Fe4
GB	T 984	EDPCrMo-A5-16

Type of coating: Low hydrogen type

Applications and Features

- (1) Weld metal contains the carbide precipitates of Cr, Mo, W and V.
- (2) It is unable to be machined and cut.
- (3) It has excellent resistance to severe metal-to-earth wear due to high hardness.
- (4) It is suitable for repairing forging molds and agitator blades.



Agitator blade

Welding Instruction

- (1) Dry the electrodes at 300-350°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	W	V
0.650	0.88	0.90	5.25	1.20	1.44	0.55

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 150^{\circ}\text{C}$		650	58	77
600°C PWHT		580	54	73
Hardness at 400°C		485	48	65
Hardness at 600°C		375	38	52

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