

Stick Electrode for Hardfacing

KH-CR25

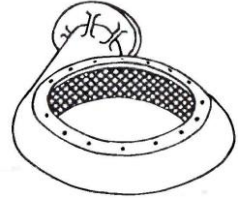
Classification

AWS	A5.13	—
JIS	Z3251	DFCrA-600-S
EN	14700	E Fe14
GB	T 984	EDZCr-B-08

Type of coating: Low hydrogen type

Applications and Features

- (1) Weld metal is a chromium carbide structure with 25% Cr.
- (2) It provides excellent hardness and abrasion resistance at high temperature due to higher chromium carbide content.
- (3) The weld metal has poor impact toughness and high crack susceptibility.
- (4) It is suitable for repairing canisters, sand-blast machines, crushers, and sieves.



Pump linings

Welding Instruction

- (1) Dry the electrodes at 300-350°C for 30-60 minutes before use.
- (2) Preheat temperature should be $\geq 250^{\circ}\text{C}$ and PWHT should be 600°C .
- (3) The surfacing should be limited to 2-3 layers.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
3.950	1.07	2.65	25.25

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)		Rockwell's hardness (HRC)		Shore's hardness (HS)	
As-welded	Interpass temp. $\leq 100^{\circ}\text{C}$	660		58		79	
	Continuous build-up	630		56		77	
Heat treatment	Temperature ($^{\circ}\text{C}$)	200	300	400	500	600	700
	Vicker's hardness	640	460	400	300	180	100

Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350
Amp	90~140	140~190	190~250