

Stick Electrode for Hardfacing

KH-CR30M

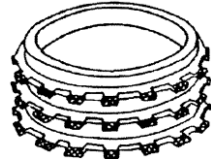
Classification

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

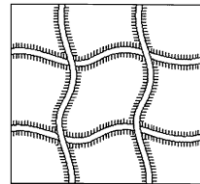
Type of coating: Special type

Applications and Features

- (1) Weld metal is a chromium carbide structure with 30%Cr and 5%Mn.
- (2) It has high amount of chromium carbide, high hardness, excellent hardness and abrasion resistance at high temperature.
- (3) It provides excellent arc -restart, good bead appearance and almost no slag.
- (4) It is suitable for repairing crusher plates, crusher teeth and mining screen.



Crusher wheel



Mining screen

Welding Instruction

- (1) Dry the electrodes at 100-200°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
3.600	0.78	5.38	30.01

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)		Rockwell's hardness (HRC)		Shore's hardness (HS)	
As-welded	Interpass temp. $\leq 100^\circ\text{C}$	630		57		77	
	Continuous build-up	610		56		74	
Heat treatment	Temperature ($^\circ\text{C}$)	200	300	400	500	600	700
	Vicker's hardness	620	450	400	300	200	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