

## Stick Electrode for Hardfacing

# KH-CRX

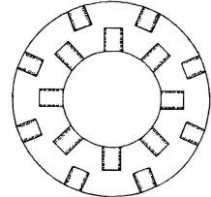
### Classification

AWS	A5.13	EFeCr-E4
JIS	Z3251	DFCrA-600-S
EN	14700	E Fe16
GB	T 984	EDZ-E4-08

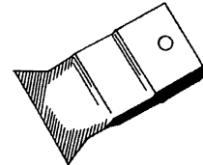
Type of coating: Special type

### Applications and Features

- (1) Weld metal contains complex carbide precipitates of Cr, Nb, Mo, W, and V. It has the best resistance to high temperature abrasion and earth abrasion. The abrasion resistance is exceptional in high temperature corrosive conditions.
- (2) It provides stable arc and almost no slag.
- (3) The service temperature can be up to 650°C. It is suitable for repairing the parts of sintering factory, blast furnace, cement plant and agricultural machines in severe earth abrasion.



Crusher wheel



Cane knives

### 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) Weld beads should be put down in grid shape to prevent the surfacing layers from spalling.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	Nb	Mo	W	V
5.530	1.95	1.32	24.64	6.92	5.65	1.97	1.63

### Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 300^\circ\text{C}$		1010	67	93

### 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