

Stick Electrode for Hardfacing

KH-13MN

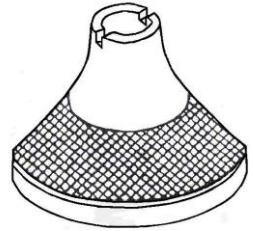
Classification

AWS	A5.13	EFeMn-A
JIS	Z3251	DFMB-400-B
EN	14700	—
GB	T 984	—

Type of coating: Low hydrogen type

Applications and Features

- (1) Weld metal is an austenite structure with 13%Mn-4%Ni and provides excellent crack resistance.
- (2) It provides good machining properties, good work-hardening properties, good toughness and good resistance to abrasion accompanied by heavy impact.
- (3) It is suitable for repairing crusher cones and studding of 13%Mn cast steel.



Crusher Cone

Welding Instruction

- (1) Dry the electrodes at 300-350°C for 30-60 minutes before use.
- (2) Preheat is not needed. Use low current to prevent overheat.
- (3) Keep good ventilation during welding.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Ni
0.680	0.50	13.51	3.71

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. ≤150°C		190	8.5	28
Work-hardened		430	43	58

Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x400	5.0x400
Amp	90~140	140~190	190~250