

Stick Electrode for Hardfacing

KH-SLA

Classification

AWS	A5.13	ECoCr-A
JIS	Z3251	DCoCrA-450-BR
EN	14700	E Co2
GB	T 984	EDCoCr-A-03

Type of coating: Lime titania type

Applications and Features

- (1) KH-SLA is a co-based hardfacing electrode (equivalent to Stellite 6) and provides corrosion and oxidation resistance. It can be applied in service temperature up to 650°C. It possesses low stress abrasion resistance.
- (2) It is suitable for high temperature abrasion with corrosive environment, such as high temperature valve seats, hot work tools, cutters, gas flow valves, turbine blades and hot press screws.
- (3) It is generally applied in steel mill, chemistry, petrification and sugar industries.

Welding Instruction

- (1) The dilution rate deteriorates the hardness and corrosion resistance.
- (2) Dragging a 90-degree angle or a short arc can reduce the dilution of weld metal.
- (3) Preheat and Int. temperature should be 400~500°C. Use slow cooling after welding to prevent cracks.
- (4) Dry the electrodes at 200-250°C for 30-60 minutes before use.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	W	Fe	Co
1.050	0.93	1.20	30.00	3.78	1.63	bal.

Typical Hardness of Weld Metal

As-welded hardness (HRC)			High temperature hardness (HRC)		
Continuous build-up	Interpass temp. 100°C	Preheat 200°C Continuous build-up	300°C	400°C	500°C
39	42	38	40	38	34

Size and Suggested Operating Range (DC+)

Diameter x Length(mm)	3.2x350	4.0x400	5.0x400
Amp	90~120	120~150	140~170