

## Stick Electrode for Hardfacing

# KH-SLB

### Classification

AWS	A5.13	ECoCr-B
JIS	Z3251	DCoCrB-500-BR
EN	14700	E Co3
GB	T 984	EDCoCr-B-03

Type of coating: Lime titania type

### Applications and Features

- (1) KH-SLB is a co-based hardfacing electrode (equivalent to Stellite 12). Its feature is similar with KH-SLA. The hardness and abrasion resistance of KH-SLB is better than KH-SLA.
- (2) It can be machined by carbide cutter.
- (3) It is suitable for injection molding screws, high temperature turbine blades, deep drawing mold and bearing.

### 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
1.350	0.93	1.36	31.78	7.86	0.82	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
43	44	42.5	47	45	40

### Size and Suggested Operating Range (DC+)

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