

# Self-Shielded Flux Cored Wire for Hardfacing

## KCH-60CR-O

### Classification

AWS	—	—
JIS	Z3326	YFCrA-G-700
EN	14700	T Fe14
GB	—	—

### Applications and Features

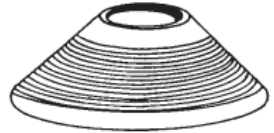
(1) Weld metal contains primary carbide and eutectic structure.

The abrasion resistance is improved due to special carbides with ultra-high hardness.

(2) It provides good weldability and almost no slag.

(3) Use 309 stainless steel electrode or KCH-13MC-O for buffer layer.

(4) It is suitable for wear plates manufacturing and repairing quarry machines, cement rolls and gyratory crusher liners.



Gyratory crusher liner

### Welding Instruction

(1) Weld metal is unable to be machined but it can be grounded if necessary.

(2) Preheat temperature should be 150~250°C for carbon steel, low alloy steel or cast steel base metal.

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

C	Si	Mn	Cr
4.50	1.50	2.00	27.00

### Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer
Hardness (HRC)	55~58	57~60	58~62

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

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
2.8	28~33	350~400	50~70