

Self-Shielded Flux Cored Wire for Hardfacing

KCH-65CZ-O

Classification

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

Applications and Features

- (1) Weld metal contains massive carbide precipitates structure.
- (2) The maximum number of layers is two.
- (3) Weld metal is unable to be machined, but it can be grounded if necessary.
- (4) It is suitable for high abrasion with low impact conditions, such as coal grinding rolls, blast furnace dome and parts of crushers.

Welding Instruction

- (1) PWHT is not needed for the weld metal.
- (2) Use carbon gouging electrode to remove the old hardfacing layer before welding.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
4.70	1.30	2.50	27.80

Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer
Hardness (HRC)	60~63	62~65	64~66

Size and Suggested Operating Range (DC+)

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