

Self-Shielded Flux Cored Wire for Hardfacing

KCH-17MN-O

Classification

AWS	—	—
JIS	—	—
EN	---	—
GB	—	—

Applications and Features

- (1) KCH-17MN-O is designed to resist abrasion and solid erosion wear combined with heavy impact.
- (2) It is designed to resist abrasion and solid erosion wear combined with heavy impact.
- (3) It is suitable for crusher hammers, gyratory crusher mantles, crusher cylinders, automobile shredder hammers.

Welding Instruction

- (1) Dry the surface of the work piece to prevent the porosity caused by moisture.
- (2) For high carbon steel or alloy steel, preheat and inter pass temperature should be 150~250°C to prevent cracks.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr	Nb
1.2	0.32	17.51	8.61	2.8

Typical Hardness of Weld Metal

	As-welded	Work-hardened
Hardness (HRC)	30-32	40-45

Size and Suggested Operating Range (DC+)

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
2.8	28~32	250~350	30~50