

K-700HT

For hardfacing (HV600-800)

Classifications

DIN 8555	: MF 10-GF-60-G
EN 14700	: T Fe16

Description

- Designed for welding metal to metal and underlaying welding of hardfacing
- Typical applications include crane wheels, blower blades, bucket lips and dredge parts
- To minimize cracking, follow recommended preheat and Interpass temperature

Welding positions



Polarity & shielding gas

- DCEP (DC+)
- CO₂: 100% CO₂ (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

Shielding Gas	C	Si	Mn	P	S	Cr	W
CO ₂	0.40	3.20	0.60	0.012	0.010	7.0	0.80

Typical mechanical properties of all-weld metal

	HV	HRC	HS	Interpass Temp	Remarks
Example (CO ₂)	600-800	55-64	74-88	200 °C	As welded

* Note: Composition and hardness depend on dilution. Single layer deposit hardness depends upon base metal and / or build-up material.

Packaging

Diameter (mm)	1.2, 1.4, 1.6
Spool (kg)	10, 15, 20