

# K-800HT

For hardfacing (HV700-850)

## Description

- Designed for heavy abrasion resistance with martensitic structure
- Typical applications include augers, bucket lips, conveyor screws, blower blades and dozer blades
- To minimize cracking, should obey the preheat and Interpass temperature

## Welding positions



## Polarity & shielding gas

- DCEP (DC+)
- CO<sub>2</sub>: 100% CO<sub>2</sub> (15 – 25 l/min)

## Typical chemical composition of all-weld metal (%)

Shielding Gas	C	Si	Mn	P	S	Cr	W
CO <sub>2</sub>	0.44	3.40	0.55	0.013	0.011	7.50	1.00

## Typical mechanical properties of all-weld metal

	HV	HRC	HS	Interpass Temp	Remarks
Example (CO <sub>2</sub> )	700-850	60-65	81-91	200	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