

# K-CCHT

For hardfacing

## Classifications

DIN 8555 : MF 10-GF-65-G

## Description

- Hard facing of sugar cane hammers and knives, crusher roll rebuilding, wear plate manufacturing, large tillage tool repair, coal pulverizer and grinding rings subject to sever abrasive wear
- Moderate to severe impact and wear by earth, sand and abrasives
- The deposit will readily show stress relief cracks

## Welding positions



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

C	Cr	Mn	Si
4.5	26.5	1.0	0.5

## Typical mechanical properties of all-weld metal

DIN	HRC	Layer *	Remark
K-CCHT	58.0	1-3	Not machinable

\* This alloy is generally limited to 3 layers.

## Recommended Welding Parameters (DCEP, DC+)

	Wire Diameter	Welding Parameters		Shield Gas
	(mm)	Amps	Volts	
K-CCHT	2.0	250 - 275	28 - 34	Open-arc
	2.8	300 - 400	30 - 34	Open-arc
	3.2	350 - 450	36 - 39	Open-arc

## Packaging

Dia. (mm)	2.0	2.8	3.2
Spool (kg)	5, 12.5, 15, 20		
Pail Pack / POP (kg)	100 - 300		