

# KM-800

For hardfacing (HV 700)

## Classifications

KS D 7035	: DF3C-700-B
JIS Z 3251	: DF3C-700-B

## Description

- Covering is low hydrogen type for hardfacing of impellers, pump casings
- The deposited weld metal has an extremely hard martensite structure
- Machining is impossible as welded
- Preheat at 200°C and over
- Postheat treat at about 600 °C immediately after welding
- Redry the electrode at 300 – 400 °C for 1 – 2 hours prior to use

## Welding positions



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

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.47	1.45	1.51	0.017	0.012	0.03	4.10	0.02	0.01

## Typical mechanical properties of all-weld metal

Conditions	As-welded		Heat treated
	Interpass temp. 150°C	Interpass temp. 200°C	600 °C stress relief
HV	723	810	535
HRC	61.1	64.4	51.4
HS	83	89	69

## Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amperage	F	90-130	140-170	190-240	220-300