

K-HCRHT

For hardfacing

Classifications

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

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
- High chromium carbide type
- The deposit will readily show stress relief cracks

Welding positions



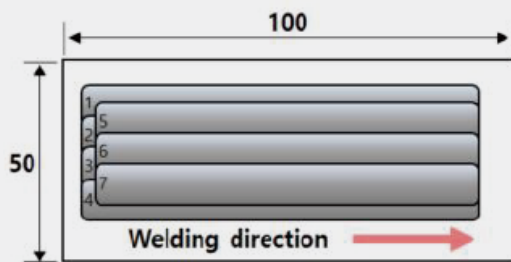
Typical chemical composition of all-weld metal (%)

C	Cr	Mn	Si	V
5.3	29.5	2.3	1.0	1.0

Typical mechanical properties of all-weld metal

DIN 8555	57 – 62 HRC	Layer *	Remark
K-CCHT	62.0	1-3	As welded

* This alloy is generally limited to 3 layers.



Diameter: 1.6mm
 Amps & Volts: 200-250A / 28-34V
 Inter-pass Temp.: Min. 250°C
 Layer: 2 Layer (7 Pass)

Bead appearance (Flat)



Recommended Welding Parameters (DCEP, DC+)

	Wire Diameter (mm)	Welding Parameters		Shield Gas
		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

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Packaging

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