

KM-650

For hardfacing

Classifications

DIN 8555 : E10-UM-60

Description

- Hardfacing of hammers, cutter knives, shovel teeth, cutter for coal, concrete cutters and earth drills
- Excellent heavy soil abrasion resistance
- Covering is high chromium carbide type
- The deposited weld metal has Cr-carbide alloy
- Machining is not possible, grinding only
- Preheat at 200 °C and higher
- Post heat treatment at 600 °C immediately after welding
- Redry the electrode at 70 – 120 °C for 30-60 minutes prior to use

Welding positions

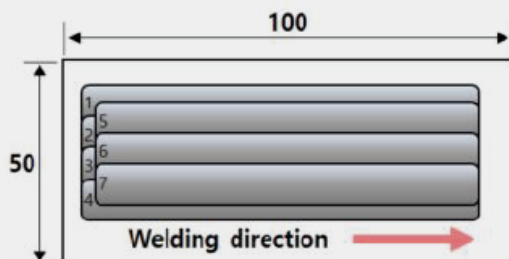


Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo
3.10	0.89	1.90	0.013	0.002	0.01	30.55	0.01

Typical mechanical properties of all-weld metal

Conditions	As-welded	
	Interpass temp. 150 °C	Interpass temp. 200 °C
HV	735	790
HRC	61.7	63.5



Size: 4.0 x 400mm
 Current & Amp.: DC (+) 170-185A
 Inter-pass Temp.: 135-170°C
 Layer: 3 Layer (9 Pass)

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amperage	F	120-150	160-200	220-260

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Bead appearance (Flat)



"Slag Removal"

