

KM-700

For hardfacing (HV 700)

Classifications

KS D 7035	: DF2B-700-B
JIS Z 3251	: DF2B-700-B

Description

- Covering is low hydrogen type for hardfacing of cutter knives, dredger and mixer
- The deposited weld metal has martensite structure
- In the case of multilayer weld build-up of base plates for hardening properties, under-laying with low hydrogen type carbon steel electrode is recommended
- Preheat at 150 °C and over in general
- 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
0.48	1.42	1.36	0.015	0.012	0.03	3.65	0.02	0.01

Typical mechanical properties of all-weld metal

Conditions	As-welded		Heat treated
	Interpass temp. 200 °C	Interpass temp. 300 °C	600 °C stress relief
HV	688	690	585
HRC	59.6	59.7	54.4
HS	81	81	73

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