

Stick Electrode for Hardfacing

KH-25-R

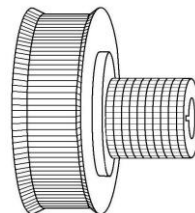
Classification

| | | |
|-----|-------|------------|
| AWS | A5.13 | EFe1 |
| JIS | Z3251 | DF2A-250-R |
| EN | 14700 | EFe1 |
| GB | T 984 | — |

Type of coating: High titania type

Applications and Features

- (1) Weld metal is a pearlite structure and has good machining properties.
- (2) It provides excellent arc re-start, slag removal and bead appearance.
- (3) KH-25-R is suitable for metal-to-metal wear due to stable hardness.
- (4) It is suitable for repairing sprockets, crane wheels, shafts and gear wheels.



Crane wheel and shaft

Welding Instruction

- (1) Dry the electrodes at 70-100°C for 30-60 minutes before use.
- (2) Clean up the contaminations on the steel to prevent porosity.
- (3) Preheat temperature should be above 150°C for multi-layer welding of low alloy steel or high carbon steel.
- (4) Welding parameter and operating technique must be carefully chosen to prevent slag inclusion in narrow gaps welding.

Typical Chemical Composition of Weld Metal (wt. %)

| C | Si | Mn | Cr |
|-------|------|------|------|
| 0.150 | 0.50 | 0.58 | 1.25 |

Typical Hardness of Weld Metal

| Condition | Hardness | Vicker's hardness (HV) | Rockwell's hardness (HRC) | Shore's hardness (HS) |
|------------------------------|----------|------------------------|---------------------------|-----------------------|
| Interpass temp. Temp. ≤150°C | | 260 | 24 | 37 |
| Continuous build-up | | 220 | 16 | 33 |

Size and Suggested Operating Range (AC or DC+)

| Diameter x Length(mm) | 2.0x250 | 2.6x300 | 3.2x350 | 4.0x350 | 5.0x350 |
|-----------------------|---------|---------|---------|---------|---------|
| Amp | 35-55 | 50-85 | 80-120 | 100-150 | 140-200 |