

## Stick Electrode for Hardfacing

# KH-50MN

### Classification

AWS	A5.13	—
JIS	Z3251	—
EN	14700	E Fe7
GB	T 984	EDCrMn-A-03

Type of coating: Lime titania type

### Applications and Features

- (1) Weld metal is martensite structure with 13%Cr and 5%Mn.
- (2) It is difficult to be machined and cut.
- (3) It provides excellent heat, corrosion and abrasion resistance. It is suitable for metal-to-metal wear; metal-to-earth wear and high temperature wear condition.
- (4) It is suitable for repairing agitator blades and heat exchanger wings.

### Welding Instruction

- (1) Dry the electrodes at 200-250°C for 30-60 minutes before use.
- (2) Clean up the contaminations on the work piece.
- (3) Preheat temperature should be above 150°C for repairing low alloy steel or medium/high carbon steel.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
0.100	0.82	5.34	11.02

### Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. ≤150°C		502	49	67
Continuous build-up		453	45	62

### Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350	6.0x400
Amp	80~120	120~170	160~210	200~280