

Stick Electrode for Hardfacing

KH-22CANE

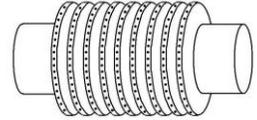
Classification

| | | |
|-----|-------|-------------|
| AWS | A5.13 | EFeCr-A1A |
| JIS | Z3251 | DFCrA-600-S |
| EN | 14700 | E Fe14 |
| GB | T 984 | EDZCr-B-08 |

Type of coating: Special type

Applications and Features

- (1) Weld metal contains carbide precipitates of Cr. It has the best resistance to high temperature abrasion and earth abrasion. The abrasion resistance is exceptional in corrosive conditions.
- (2) The service temperature can be up to 650°C.
- (3) It provides stable arc, easy arc re-start and almost no slag.
- (4) It is specially designed for repairing pressing roller of sugar refinery due to its corrosion resistance to sugar cane juice.
- (5) It provides a hemisphere weld bead.



Pressing roller

Welding Instruction

- (1) Dry the electrodes at 100-200°C for 30-60 minutes before use.
- (2) Preheat temperature should be $\geq 250^{\circ}\text{C}$ and PWHT should be 600°C.
- (3) Weld beads should be put down in grid shape to prevent the surfacing layers from spalling.

Typical Chemical Composition of Weld Metal (wt. %)

| C | Si | Mn | Cr |
|-------|------|------|-------|
| 3.600 | 4.20 | 1.20 | 22.00 |

Typical Hardness of Weld Metal

| Condition | Hardness | Vicker's hardness (HV) | Rockwell's hardness (HRC) | Shore's hardness (HS) |
|-----------|--|------------------------|---------------------------|-----------------------|
| As-welded | Interpass temp. $\leq 150^{\circ}\text{C}$ | 1010 | 67 | 93 |

Size and Suggested Operating Range (AC or DC+)

| | | | |
|-----------------------|---------|---------|---------|
| Diameter x Length(mm) | 3.2x350 | 4.0x350 | 5.0x350 |
| Amp | 90~140 | 140~190 | 190~250 |