

Stick Electrode for Hardfacing

KH-W

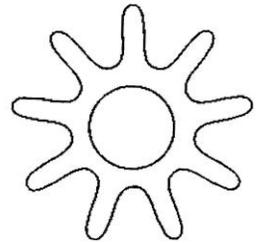
Classification

AWS	A5.13	—
JIS	Z3251	DFWA-700-S
EN	14700	—
GB	T 984	EDW-A-08

Type of coating: Special type

Applications and Features

- (1) Weld metal contains massive tungsten carbide structure with extremely high hardness.
- (2) It is unable to be machined due to its high hardness.
- (3) It provides excellent arc re-start and almost no slag.
- (4) It is used in severe earth abrasion with low impact conditions.
- (5) It is suitable for repairing oil drilling, mining and dredging equipment.



Dredge agitator

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	W	Fe
3.150	0.30	2.10	42.3	bal.

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 300^{\circ}\text{C}$		760	68	85
Continuous build-up		645	67	77

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