

Gas Welding And GTAW Wire

KTS-06

KTS-12

KTS-01

Classification

AWS	A5.13	—
JIS	Z3251	—
EN	14700	S Co2/ S Co3/ S Co1
GB	T 984	—

Applications and Features

- (1) KTS-06, KTS-12 and KTS-01 are suitable for GTAW and gas welding.
- (2) KTS-06 is a co-based solid welding wire (equivalent to Stellite 6) and provides corrosion and oxidation resistance. It is suitable for repairing high temperature high pressure valve seats, plate seats of crusher, cutters, spiral screws and feeder screws.
- (3) KTS-12 is a co-based solid welding wire (equivalent to Stellite 12), and its feature is similar with KTS-06. It is suitable for repairing valves, shafts, rotary shafts, belt conveyors and spindles of internal combustion engines.
- (4) KTS-01 is a co-based solid welding wire (equivalent to Stellite 1) and its feature is similar with KTS-06 and KTS-12. However, the impact and corrosion resistance might be lower.

Welding Instruction

- (1) Please apply appropriate preheat and post heat treatment.
- (2) Remove the sharp angle and scale before welding.
- (3) Preheat the base metal by reducing the frame to (1:3) before gas welding.

Typical Chemical Composition of Weld Metal (wt. %)

Product	C	Cr	W	Fe	Co
KTS-06	1.12	28.02	4.19	1.27	bal.
KTS-12	1.57	28.40	8.20	1.36	bal.
KTS-01	2.32	28.80	12.70	1.42	bal.

Typical Hardness of Weld Metal

Product	As-welded hardness (HRC)
KTS-06 / G-6-A	42
KTS-12 / G-12-B	48
KTS-01 / G-1-C	56