

Stick Electrode for Hardfacing

KCH-13MC-O

Classification

AWS	—	—
JIS	Z3326	YFME-G-250
EN	14700	—
GB	—	—

Applications and Features

- (1) KCH-13MC-O is a self-shielded flux cored wire of Cr-Mn alloy.
- (2) It is used as a buffer layer before hardfacing. Weld metal can be machined and cut.
- (3) It is suitable for the buffer layer of coal pulverizer and repairing the worn work piece which is caused by heavy impact and wear.

Welding Instruction

- (1) Dry the surface of work piece to prevent the porosity caused by moisture.
- (2) For high carbon steel or alloy steel, preheat and interpass temperature should be 150~250°C to prevent cracks.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
0.50	0.50	11.50	18.00

Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer
Hardness (HRC)	21~24	22~26	25~28

Size and Suggested Operating Range (DC+)

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
2.4	26~30	200~340	50~60
2.8	28~32	250~400	50~70