

## Submerged Arc Flux-Cored Wire / Flux

# KF-810 KCH-17-SX

### Classification

AWS	—	—
JIS	—	—
EN	14700	UP3-GF-350-P
GB	—	—

### Applications and Features

- (1) KCH-17-SX and KF-810 are a submerged arc flux-cored wire and a flux which produces a low carbon, low alloy weld deposit with a typical hardness of 35 HRC.
- (2) It provides not only good metal-to-metal abrasion resistance but also good resistance to compression and cold work deformation. The impact resistance is excellent and the crack susceptibility is low.
- (3) There is no hot crack for multi-layer build-up up to 20 mm.
- (4) The weld metal can be machined and cut after welding.
- (5) It is suitable for repairing crane wheels, idlers and mine car wheels.

### Welding Instruction

- (1) The hardness of weld metal will decrease when the temperature of stress relief exceeds 480°C.
- (2) The preheat and interpass temperature should be controlled between 200-400°C for massive work pieces and high curvature surface to prevent weld cracking caused by high stress.

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

C	Si	Mn	Cr	Mo
0.080	0.60	2.60	3.0	0.8

### Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer
Hardness (HRC)	26~30	30~35	34~38

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

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
3.2	30~32	380~400	25~30