

Submerged Arc Flux-Cored Wire / Flux

KF-810 KCH-31-SX

Classification

AWS	—	Alloy Group 1-A
JIS	—	—
EN	14700	UP1-GF-300-P
GB	—	—

Applications and Features

- (1) Weld metal is martensite structure with low carbon and low alloy content.
- (2) It can be machined, forged and hardened.
- (3) It is suitable for repairing continuous casting rolls, steel mill rolls, shafts and idlers. It can also be used as the buffer layer for hardfacing.

Welding Instruction

- (1) The DC (+) polarity is recommended, but AC polarity can be used in some special automatic application.
- (2) The dust, oil and moisture of surface should be removed before welding. If weld surface has crack or chip, please use a low hydrogen electrode to fill it before repairing.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Mo
0.150	0.50	2.70	0.60

Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer
Hardness (HRC)	18~24	24~27	29~32

Size and Suggested Operating Range (DC+)

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
3.2	24~27	29~32	18~24