

Submerged Arc Flux-Cored Wire / Flux

KF-810 KCH-420-SX

Classification

AWS	—	—
JIS	—	—
EN	14700	UP6-GF-50-C
GB	—	—

Applications and Features

- (1) Weld metal has chemical composition that conforms AISI 420 martensitic stainless steel.
- (2) It provides good slag removal, excellent crack resistance and unlimited deposition thickness.
- (3) It is suitable for the reclamation of continuous casting rolls, blast furnace domes, print rolls and gudgeon.

Welding Instruction

- (1) Please preheat at 200~250°C when the carbon content of the carbon steel work piece is over 0.8 wt% or the low alloy steel work piece is over 0.35wt%.
- (2) Preheat and interpass temperatures should be controlled between 200-250°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
0.210	0.55	1.25	13.2

Typical Hardness of Weld Metal

	1st layer	2nd layer	3rd layer	4th layer
Hardness (HRC)	43.9	46.8	47.1	48.1

Size and Suggested Operating Range (DC+)

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
3.2	30~32	400~450	25~30