KUANG TAI

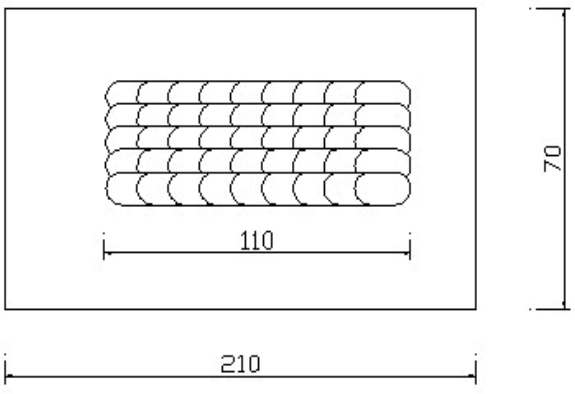
KCH-13MC-O

Product Data Sheet — **Self-Shielded Flux Cored Wire for Hardfacing**

Specification	DIN 8555 : MF7-GF-200/50-KP
Applications	● It is suitable for buffer layer of coal pulverizer and repair of worn work piece which is caused by heavy impact and wear.
Characteristics	● Weld metal is Cr-Mn austenitiic structure. ● High toughness and good work-hardening. ● Good weldability and slag removal.
Note on Usage	● Dry and clear the surface of work piece to pre prevent the porosity caused by moisture. ● For high carbon steel or alloy steel, preheat and interpass temperature is 150~250℃ to prevent the crack.

Chemical Composition & Hardness of All Weld Metal

Welding Conditions



[Joint Preparation & Layer Details]

Method by AWS Rules

Diameter(mm)	2.8
Shielding Gas	None
Flow Rate (l/min)	None
Amp / Volt	300 / 32
Stick-Out (mm)	30
Interpass Temp (℃)	150±15
Polarity	DC(+)

Hardness of Weld Metal

Layer	1	2	3	Work-Hardened
Hardness (HRC)	8~10	10~12	10~14	45~50

Chemical Analysis of the Weld Metal

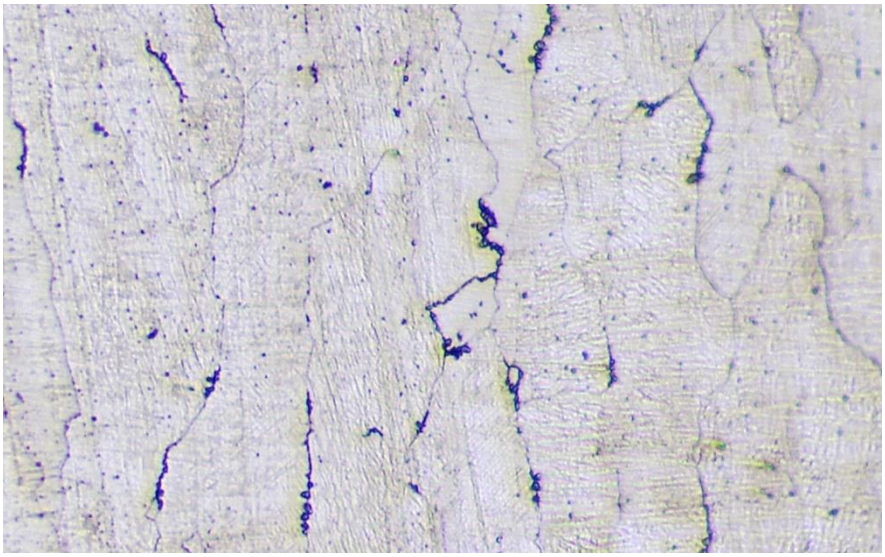
Unit: wt%

Brand Name	C	Si	Mn	P	S	Cr
KCH-13MC-O	0.2	0.5	15.7	0.035	0.021	12.31

Available Sizes and Suggested Operating Range

Size (mm)	Voltage （V）	Current（A）	ESO（mm）
2.8	28~33	350~400	40~60

Microstructure of all weld metal



KCH-13MC-O produces an austenitic structure. Austenitic structure possesses high toughness and high work-hardening ability.