



KCH-65CZ-O

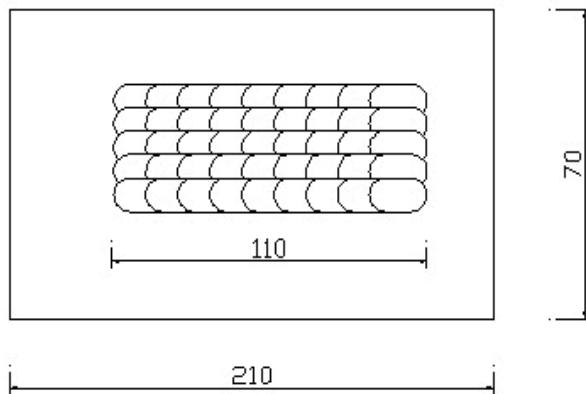
Product Data Sheet

Self-Shielded Flux Cored Wire for Hardfacing

Specification	DIN 8555 : MF 10-GF-65-G
Applications	It is suitable for high abrasion with low impact condition such as coal grinding rolls, blast furnace dome and parts of crushers.
Characteristics	<ul style="list-style-type: none">● Weld metal contains massive carbide precipitates structure.● The abrasion resistance is improved due to special carbides with ultrahigh hardness.● Good weldability and almost no slag.
Note on Usage	<ul style="list-style-type: none">● Weld metal is unable to be machined, but it can be ground if necessary.● The maximum number of layers is three.● Use carbon gouging electrode to remove old hardfacing layer before welding.● PWHT is not needed for weld metal.

Chemical Composition & Hardness of All Weld Metal

Specimen specification and welding parameter



Diameter (mm)	2.8
Current (A)	300
Voltage (V)	32
Interpass	
Temperature (° C)	150±15
Shielding Gas	None
Polarization	DC(+)

- **Hardness of Weld Metal**

Layer	1	2	3
Hardness (HRC)	55~57	57~63	63~65

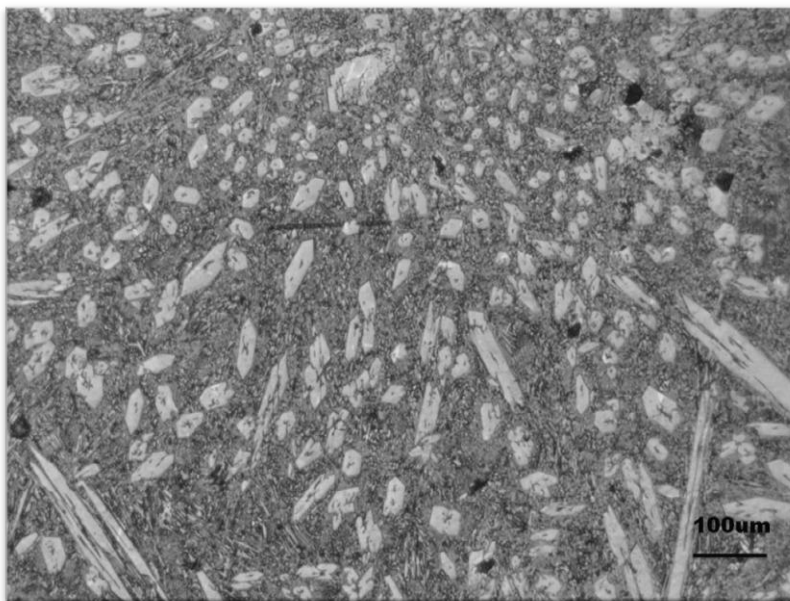
- **Chemical Composition of Weld Metal**

C	Si	Mn	P	S	Cr	Other
4.2	0.5	1.1	0.02	0.02	27.47	0.13

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-65CZ-O produces a high concentration of small primary and special carbides in comparison to a standard chromium carbide deposit. It results in a significant improvement in wear performance.

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of Kuang Tai Metal IND CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.