KM-1000

For hardfacing (Hv 800)

Classifications

KS D 7035 : DFWA-700-S
JIS Z 3251 : DFWA-700-S

Description

- Hardfacing of cutter knives, shovel teeth, cutter for coal, concrete cutters and earth drills.
- The deposited weld metal is harder than other kinds of deposited weld metal.
- Extremely excellent heavy soil abrasion resistance.
- The deposited weld metal has tungsten carbide alloy.
- Machining is impossible.
- Preheat at 300℃ and high over.
- Postheat treat at about 600℃ immediately after welding.
- Redry the electrode at 70~120℃ for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
2.98	0.60	1.88	0.022	0.014	0.04	0.02	0.01	48.0

Typical mechanical properties of all-weld metal

Conditions	As welded Interpass temp. max. 350℃
HV	820
HRC	64.7
HS	90

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	90~130	120~180	170~230