Covered Electrodes

KM-300

For hardfacing (Hv 300)

Classifications

EN 14700:2005 : E Fe 1
KS D 7035 : DF2A-300-B
JIS Z 3251 : DF2A-300-B

Description

- Covering is low hydrogen type for hardfacing of shafts, roller, spindle, crane wheel, etc.
- Good usability.
- High abrasion resistance and impact resistance.
- Good machinable the deposited weld metal.
- Preheat at 150℃ only for multilayer welding of low alloy steell and high carbon steel.
- Redry the electrode at 300~400℃ for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.20	0.60	1.48	0.018	0.011	0.02	0.70	0.01	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded	Heat treated	
	Interpass temp. 150℃	900℃ oil quenching	650℃ stress relief
HV	308	408	280
HRC	30.8	41.6	27.1
HS	43	56	40

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F	80~130	140~180	170~240	240~300