KM-800D

For Cement industry

Classifications

DIN 8555 : E6-UM-60

Description

- Covering is low hydrogen type for hardfacing of impellers, pump casings.
- The deposited weld metal has an extremely hard martensite structure.
- Machining is impossible as welded.
- Preheat at 200℃ and over.
- Postheat treat at about 600℃ immediately after welding.
- 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	Cr	Ni	Mo
0.56	1.93	0.36	0.011	0.004	10.32	0.05	0.02

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Interpass temp. 150℃	Interpass temp. 200℃
HV	702	760
HRC	60.2	62.8

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	140~170	190~240