KM-900

For hardfacing (Hv 700)

Classifications

KS D 7035 : DFMA-250-B
JIS Z 3251 : DFMA-250-B

Description

- Covering is high titania type for hardfacing of crushers, high manganese rails, buckets, bulldozer parts and build-upof parts subject to serene impact and abrasion.
- The deposited weld metal has austenite structure.
- Extremely ductile deposited weld metal.
- When the base metal of 13% Mn steel is hardened, cut off the hardened zone before 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	Ni	Cr	Mo	W
0.52	0.30	12.10	0.018	0.012	0.02	0.10	0.20	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded Interpass temp. 150℃	Work hardenability
HV	225	510
HRC	16.9	49.8
HS	33	66.5

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	90~130	140~180	190~240	220~300