

# Stick Electrode for Hardfacing

## KH-40-B

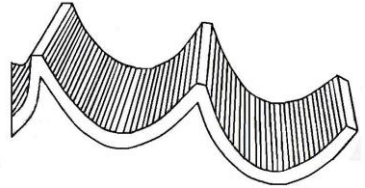
### Classification

AWS	A5.13	EFe2
JIS	Z3251	DF2A-400-B
EN	14700	E Fe2
GB	T 984	EDPCrMo-A2-16

Type of coating: Low hydrogen type

### Applications and Features

- (1) Weld metal is martensite structure and has acceptable machining properties.
- (2) It provides good crack resistance and impact and medium abrasion.
- (3) It is suitable for repairing drive sprockets, idlers, pulleys, caterpillar bands, crusher rolls, buckets, chains and shafts.



Caterpillar band

### Welding Instruction

- (1) Dry the electrodes at 300-350°C for 30-60 minutes before use.
- (2) Clean up the contaminations on the steel. Keep arc as short as possible.
- (3) Take the back-step method to prevent porosity at the arc starting.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
0.200	0.45	1.25	2.20

### Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 150^{\circ}\text{C}$		430	43	58
Continuous build-up		380	38	52
Water quenching at $900^{\circ}\text{C}$		450	45	61

### Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350	6.0x400
Amp	70~120	100~170	160~220	200~280