

Stick Electrode for Hardfacing

KH-45-B

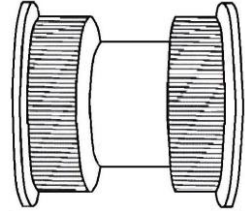
Classification

AWS	A5.13	EFe2
JIS	Z3251	DF2A-450-B
EN	14700	E Fe2
GB	T 984	EDPCrMp-A2-16

Type of coating: Low hydrogen type

Applications and Features

- (1) Weld metal is martensite structure and difficult to be machined.
- (2) It provides good crack resistance, impact and medium abrasion.
- (3) It is suitable for repairing crane wheels, bulldozer, stone crushers, hitch rings, bucket ladders, caterpillar bands, canisters, shafts and blades.



Pilot wheel

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.
- (4) Preheat and Interpass temperature should be $\geq 150^{\circ}\text{C}$.
- (5) Use high tensile strength low hydrogen electrode for the buffer layer in multi-layer build-up.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	Cr
0.320	0.35	1.30	2.60

Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
Interpass temp. $\leq 150^{\circ}\text{C}$		450	45	60
Continuous build-up		400	40	55
Tempering at 600°C		350	35	48

Size and Suggested Operating Range (AC or DC+)

Diameter x Length(mm)	3.2x350	4.0x350	5.0x350	6.0x400
Amp	80~120	120~170	160~210	200~280