

# Stick Electrode for Hardfacing

## KH-50

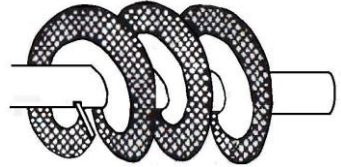
### Classification

AWS	A5.13	—
JIS	Z3251	DF4B-600-BR
EN	14700	E Fe8
GB	T 984	EDCr-B-03

Type of coating: Lime titania type

### Applications and Features

- (1) Weld metal is martensite structure with 13%Cr.
- (2) Due to the high hardness of the weld metal, preheat and stress relieving is required to prevent cracks.
- (3) It provides excellent corrosion resistance; acid resistance and impact wear resistance at high temperature.
- (4) It is suitable for repairing conveyers, crane wheels, drive tumblers and chemical conveying screws.



Mixer Screw

### Welding Instruction

- (1) Dry the electrodes at 200-250°C for 30-60 minutes before use.
- (2) Preheat temperature should be above 200°C. Use slow cooling and stress relieving after welding.

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

C	Si	Mn	Cr
0.200	0.40	0.20	11.50

### Typical Hardness of Weld Metal

Condition	Hardness	Vicker's hardness (HV)	Rockwell's hardness (HRC)	Shore's hardness (HS)
As-welded	Interpass temp. ≤150°C	528	51	68
	Continuous build-up	510	50	67
Work-hardened		630	56	75
High Temp.	Temperature (°C)	200	300	400
	Vicker's hardness	470	410	300

### 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