

FOR HARDFACING

JIS DFWA-700-S
KS DFWA-700-S

KM-1000

Typical applications

Hardfacing of cutter knives, shovel teeth, cutters for coal, concrete cutters and earth drills.

Coating

Special type.

Characteristics on Usage

- ① The deposited weld metal is harder than other kinds of deposited weld metal.
- ② Extremely excellent heavy soil abrasion resistance.
- ③ The deposited weld metal has tungsten carbide alloy.
- ④ Machining is impossible.
- ⑤ Preheat at 300°C and over.
- ⑥ Postheat treat at about 600°C immediately after welding.
- ⑦ Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

| C | Si | Mn | W |
|------|------|------|------|
| 2.98 | 0.60 | 1.88 | 48.0 |

Typical mechanical properties of all-weld-metal

| Conditions | As welded | |
|------------|---|--|
| | Preheat and interpass temperature 350°C | |
| HV | 820 | |
| HRC | 64.7 | |
| HS | 90 | |

Sizes available and recommended currents (AC or DC ⊕)

| | | | |
|-------------|----------|---------|---------|
| Dia. (mm) | 3.2 | 4.0 | 5.0 |
| Length (mm) | 350 | 400 | 400 |
| Amp. | F 90~130 | 120~180 | 170~230 |

Welding positions



Approved by