

KM-11Cr

JIS DF4B-500-B
KS DF4B-500-B

FOR HARDFACING

Typical applications

Hardfacing of cold or hot shearer blade, liner pump casing generator-water turbine, liner dredger.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The deposited weld metal has the microstructure of martensite.
- ② Abrasion resisting properties is good at elevated temperature, so it is used for repairing of hot tool.
- ③ Preheating is not necessary in general, but preheat at 150°C and over only for high carbon steels and low alloy steels.

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

C	Si	Mn	Cr	Mo
0.40	1.28	0.46	11.2	1.4

Typical mechanical properties of all-weld-metal

Conditions	As welded
	Interpass, temperature 150°C
HV	540
HRC	51.7
HS	69

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Amp.	F 90~110	110~150	150~200

Welding positions



Approved by