

FOR HARDFACING

# KM-13CrM

## Typical applications

Hardfacing of hot roller dies, tong punch and hot cutting knife, etc.

## Coating

Lime titania type.

## Characteristics on Usage

- ① The deposited weld metal has the microstructure of a fine carbide precipitation in austenite matrix.
- ② The high temperature hardness over 600°C is high, so it has excellent abrasion-resistance.
- ③ Machining is possible in general.
- ④ Good bead appearance and restriking properties, 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	W	Mo
0.30	0.48	12.4	11.8	1.8	1.5

## Typical mechanical properties of all-weld-metal

Conditions	As welded
HV	310
HRC	31
HS	43

## Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	4.0	5.0
Length	(mm)	400	400
Amp.	F	140~180	180~230

## Welding positions



Approved by