

# KM-500

JIS  
KS

DF2B-450-B  
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FOR HARDFACING

## Typical applications

Hardfacing of idlers, rollers, bulldozer blades, sprockets, caterpillar links, crushers, dipper teeth and conveyors, etc.

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① The deposited weld metal has typical martensite structure and high grade of hardness and ductility as welded.
- ② Machining is impossible as welded.
- ③ Preheat at about 150°C and over in general.
- ④ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr
0.38	0.84	1.56	2.5

## Typical mechanical properties of all-weld-metal

Conditions	As welded		Heat treated (furnace cooling)	
	Interpass temperature 150°C	Interpass temperature 300°C	550°C×6hr.	625°C×6hr.
HV	452	408	443	348
HRC	45.5	41.6	44.8	35.8
HS	60	56	59	48

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

Dia. (mm)	3.2	4.0	5.0	6.0
Length (mm)	350	400	400	450
Amp.	F 80~120	130~170	170~220	220~280

## Welding positions



Approved by