

FOR HARDFACING

JIS DF2B-700-B
KS DF2B-700-B

KM-700

Typical applications

Hardfacing of cutter knives, dredger and mixer.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The deposited weld metal has martensite structure.
- ② In the case of multilayer build-up welding base plates of hardening properties, under-laying with low hydrogen type carbon steel electrode.
- ③ Preheat at 150°C and postheat at 600°C

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

C	Si	Mn	Cr
0.48	1.42	1.36	3.9

Typical mechanical properties of all-weld-metal

Conditions	As welded		Heat treated
	Interpass temperature 200°C	300°C oil quenching	600°C stress relief
HV	688	690	585
HRC	59.6	59.7	54.4
HS	81	81	73

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 90~130	140~170	190~240	220~300

Welding positions



Approved by