

KM-800

JIS DF3C-700-B
KS DF3C-700-B

FOR HARDFACING

Typical applications

Hardfacing of impellers, pump casings.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The deposited weld metal has an extremely hard martensite structure.
- ② Machining is impossible as welded.
- ③ Preheat at 200°C and over.
- ④ Postheat treat at about 600°C immediately after welding.
- ⑤ 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
0.47	1.45	1.51	4.1

Typical mechanical properties of all-weld-metal

Conditions	As welded		Heat treated
	Interpass temperature 150°C	300°C oil quenching	600°C stress relief
HV	723	810	535
HRC	61.1	64.4	51.4
HS	83	89	69

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