

KOSPEL-600H

FOR HARDFACING

Typical applications

Hardfacing of metal mould, thermal cutting off machine, forging mould, dotting punch, compression tap, impact tap and axis of rotation.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The microstructure of deposited weld metal has martensite.
- ② Preheat at 200~300°C and postheat treat at 500~600°C, if possible.
- ③ Keep up interpass temperature same as preheating temperature, if possible.
- 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	W	V
0.25	0.59	0.95	2.5	4.2	1.0

Typical mechanical properties of all-weld-metal

Conditions	As welded		Heat treated (Air cooling)			
	Continuous surfacing	Preheat and interpass temperature 150°C	350°C ×2hr	550°C ×2hr	650°C ×2hr	780°C ×2hr
HV	520~570	560~600	570~620	640~690	530~580	280~320
HRC	51~54	53~55	54~56	57~60	51~54	27~32
HS	67~71	71~74	71~75	77~81	67~72	40~45

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	90~130	100~150	120~170	150~200

Welding positions



Approved by