KOSPEL-800R

FOR HARDFACING

Typical applications

Hardfacing of conveyor screw, caterpillar, crusher and dredger teeth.

Coating

Lime titania type.

Characteristics on Usage

- 1) Excellent friction and impact abrasion resisting properties.
- ② Preheat at 200°C and postheat treat at 500~600°C.
- ③ Redry the electrode at 150~200℃ for 30~60 minutes prior to use.

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

С	Si	Mn	Cr	Мо	V
0.38	0.42	0.32	5.5	2.5	0.8

Typical mechanical properties of all-weld-metal

Conditions	As welded			
Conditions	Continuous surfacing	Preheat and interpass temperature 300 ${\tt C}$		
HV	760~820	700~750		
HRC	63~65	60~62		
HS	86~90	81~85		

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	400	400
Amp.	F	80~140	90~160	120~180	140~200

Welding positions





Approved by