

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°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr	Mo	V
0.38	0.42	0.32	5.5	2.5	0.8

Typical mechanical properties of all-weld-metal

Conditions	As welded	
	Continuous surfacing	Preheat and interpass temperature 300°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