

KQD-600

FOR HARDFACING

Typical applications

Hardfacing of press mould, forged metal mould, tool steel and hardened part by quenching.

Coating

Lime titania type.

Characteristics on Usage

- ① The microstructure of deposited weld metal has martensite.
- ② Excellent impact-resisting and wear-resisting properties at high temperature as well as room temperature.

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

C	Si	Mn	Cr	Mo	W
0.30	0.36	0.28	9.4	1.3	12.1

Typical mechanical properties of all-weld-metal

Conditions	As welded	
	Continuous surfacing	Interpass temperature max.100℃
HV	580~620	590~610
HRC	54~56	55~56
HS	72~75	73~75

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	2.6	3.2	4.0
Length (mm)	350	350	350
Amp.	F 70~90	100~120	130~170

Welding positions



Approved by