

Covered Electrodes

KM-250

For hardfacing (Hv 250)

Classifications

EN 14700:2005	: E Fe 1
KS D 7035	: DF2A-250-B
JIS Z 3251	: DF2A-250-B

Description

- Covering is low hydrogen type for hardfacing and repairing of worn parts such as shafts, gears, wheels, etc.
- Stable arc, smooth bead appearance and easy slag removal.
- High abrasion resistance and impact resistance.
- Good machinable the deposited weld metal.
- Preheat at 150~200°C only for multilayer welding of low alloy steel and high carbon steel.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.18	0.69	2.28	0.013	0.009	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded	Heat treated	
	Interpass temp. 150°C	900°C oil quenching	650°C stress relief
HV	278	395	250
HRC	26.8	40.3	22.2
HS	39	54	36

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. (A)	F	90~130	140~180	180~240	220~300