

Covered Electrodes

KM-700

For hardfacing (Hv 700)

Classifications

KS D 7035 : DF2B-700-B
JIS Z 3251 : DF2B-700-B

Description

- Covering is low hydrogen type for hardfacing of cutter knives, dredger and mixer.
- The deposited weld metal has martensite structure.
- In the case of multilayer build-up welding base plates of hardening properties, under-laying with low hydrogen type carbon steel electrode.
- Preheat at 150°C and over in general.
- 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
0.48	1.42	1.36	0.015	0.012	0.03	3.65	0.02	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded		Heat treated
	Interpass temp. 200°C	Interpass temp. 300°C	600°C stress relief
HV	688	690	585
HRC	59.6	59.7	54.4
HS	81	81	73

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	140~170	190~240	220~300