

Covered Electrodes

KQD-600

For hardfacing (High Cr&W, Hv 600)

Description

- Covering is low hydrogen type for hardfacing of press mould, forged metal mould, tool steel and hardened part by quenching.
- The microstructure of deposited weld metal has martensite.
- Excellent impact-resisting and wear-resisting properties at high temperature as well as room temperature.
- 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
0.30	0.36	0.3	0.035	0.009	0.45	9.4	1.3	12.1

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Continuous surfacing	Interpass temp, max. 100°C
HV	580-620	590-610
HRC	54-56	55-56
HS	70-75	73-75

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	70-90	100-120	130-170