

Covered Electrodes

KM-11Cr

For hardfacing (High Cr, Hv 500)

Classifications

KS D 7035 : DF4B-500-B
JIS Z 3251 : DF4B-500-B

Description

- Covering is low hydrogen type for hardfacing of cold or hot shearer blade, liner pump casing generator water turbine, liner dredger.
- The deposited weld metal has the microstructure of martensite.
- Abrasion resisting properties is good at elevated temperature, so it is used for repairing of hot tool.
- Preheating is not necessary in general, but preheat at 150 and over only for high carbon steels and low alloy steels.
- 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
0.40	1.28	0.46	0.025	0.010	0.35	11.2	1.40	0.01

Typical mechanical properties of all-weld metal

Conditions	As welded Interpass temp. 150°C	
HV	540	
HRC	51.7	
HS	69	

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	90~110	110~150	150~200