

# K-600HT

For hardfacing (Hv550~700)

## Classifications

JIS Z 3326 : YF3B-C-600

## Description

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include crane wheels, blower blades, bucket lips, dredge parts etc
- In order to minimize cracking, should obey the preheat and interpass temperature

## Welding positions



## Polarity & shielding gas

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

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

Shielding gas	C	Si	Mn	P	S	Cr	Mo
CO <sub>2</sub>	0.34	2.80	0.50	0.013	0.009	6.50	0.50

## Typical mechanical properties of all-weld metal

	Hv	Typical value HRC	Hs	Interpass Temp(°C)	Remarks
Example (CO <sub>2</sub> )	550~700	52~60	69~81	200	As weld

\* Composition and hardness depend upon dilution. Single layer deposit hardness depend upon base metal and/or build-up material.

## Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	10, 15, 20		