

# K-800HT

For hardfacing (Hv700~850)

## Description

- It is designed for heavy abrasion resistance with martensitic structure
- Typical applications include augers, bucket lips, conveyor screws, blower blades, dozer blades
- 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	W
CO <sub>2</sub>	0.44	3.40	0.55	0.013	0.011	7.50	1.00

## Typical mechanical properties of all-weld metal

	Hv	Typical value HRC	Hs	Interpass Temp (°C)	Remarks
Example (CO <sub>2</sub> )	700~850	60~65	81~91	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		