K-250HT

For hardfacing (Hv200~300)

Classifications

EN ISO 14700:2005 : T Fe1 JIS Z 3326 : YF2A-C-250

Description

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- In order to minimize cracking, should obey the preheat and interpass temperature
- It has low spatter generation, easy slag removal and reduced grinding time after work hardening

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr
CO_2	0.07	0.50	1.59	0.013	0.011	1.30

Typical mechanical properties of all-weld metal

	Typical value				
	Hv	HRC	Hs	Interpass Temp(℃)	Remarks
Example (CO_2)	200~300	11~29	29~42	150	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		