

CD-600

For hard facing

Applications

Hard-surfacing of press mould, forged metal mould, tool steel and hardened part by quenching.

Characteristics

- (1) Lime titania type.
- (2) Excellent impact-resisting and wear-resisting properties at high temperature as well as room temperature.
- (3) It has good slag removal and bead appearance.

Notes on usage

- (1) Preheat at 100~300°C.
- (2) Keep the length of bead less than 50mm in the quenching part, hardening part.
- (3) Keep the temperature of inter-pass less than 100°C.
- (4) In the case of multi-lay build-up welding or welding mother plates with hardening property, under-lay with low hydrogen type electrodes for mild steel.

Typical chemical composition of weld metal (%)

C	Si	Mn	P	S	Cr	Mo	W
0.43	0.72	0.20	0.018	0.009	8.30	1.51	11.50

Typical hardness of weld metal

As welded	Hv	H _R C
Continuous surfacing	580-630	54-58
Interpass temperature max. 100°C	590-610	55-58

Size & recommended current range (AC or DC +)

Dia. (mm)		2.6	3.2	4.0
L (mm)		300	350	400
Amp.	F	70-90	100-120	120-140

• Tip Color : black