

## Covered Electrodes

# KM-650

For Cement industry

### Classifications

DIN 8555 : E10-UM-60

### Description

- Hardfacing of cutter knives, shovel teeth, cutter for coal, concrete cutters and earth drills.
- The deposited weld metal is harder than other kinds of deposited weld metal.
- Extremely excellent heavy soil abrasion resistance.
- The deposited weld metal has Cr-carbide alloy.
- Machining is impossible.
- Preheat at 200°C and high over.
- Postheat treat at about 600°C immediately after welding.
- Redry the electrode at 70-120°C for 30-60 minutes prior to use.

### Welding positions



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

C	Si	Mn	P	S	Cr	Ni	Mo
3.10	0.89	1.90	0.013	0.002	30.55	0.01	0.01

### Typical mechanical properties of all-weld metal

Conditions	As welded	
	Interpass temp. 150°C	Interpass temp. 200°C
HV	735	790
HRC	61.7	63.5

### Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	120~150	160~200	220~260