

Covered Electrodes

KOSPEL-800R

For hardfacing (Hv 800)

Description

- Covering is lime titania type for hardfacing of conveyor screw, caterpillar, crusher and dredger teeth.
- Excellent friction and impact abrasion resisting properties.
- Preheat at 200°C and postheat treat at 500-600°C.
- 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	Ni	Cr	V	Mo
0.38	0.42	0.32	0.025	0.015	0.04	5.5	0.8	2.5

Typical mechanical properties of all-weld metal

Conditions	As welded	
	Continuous surfacing	Preheat and interpass tem. max 300°C
HV	760~820	700~750
HRC	63~65	60~62
HS	86~90	81~85

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F	80~140	90~160	120~180	140~200