



JS WEAR SOLUTIONS

KCH-615-S

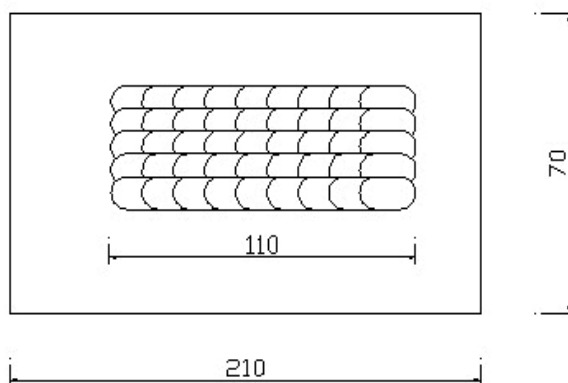
Product Data Sheet

Self-Shielded Flux Cored Wire for Hardfacing

Specification	DIN 8555 : MF7-GF-200/50-KP
Applications	It is suitable for buffer layer of coal pulverizer and repair of worn work piece which is caused by heavy impact and wear.
Characteristics	● Weld metal is Cr-Mn austenitic structure. ● High toughness and good work-hardening. ● Good weldability and slag removal.
Note on Usage	● Dry and clear the surface of work piece to prevent the porosity caused by moisture. ● For high carbon steel or alloy steel, preheat and interpass temperature is 150~250°C to prevent the crack.

Chemical Composition & Hardness of All Weld Metal

Specimen specification and welding parameter



Diameter (mm)	2.8
Current (A)	300
Voltage (V)	32
Interpass Temp (° C)	150±15
Shielding Gas	None
Polarization	DC(+)

- **Hardness of Weld Metal**

Layer	1	2	3	Work-Hardened
Hardness (HRC)	8~10	10~12	10~14	45~50

- **Chemical Composition of Weld Metal**

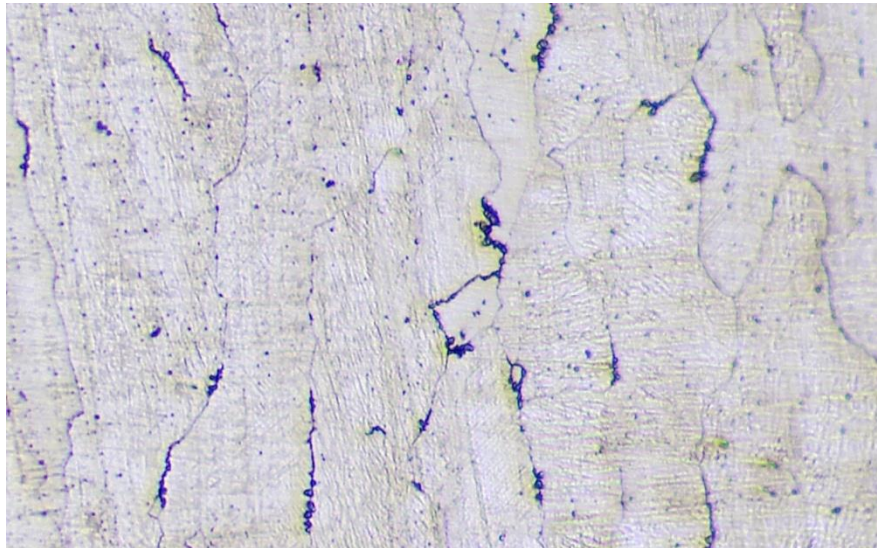
unit: wt.%

C	Si	Mn	P	S	Cr
0.2	0.5	15.7	0.035	0.021	12.31

Available Sizes and Suggested Operating Range

Size (mm)	Voltage (V)	Current (A)	ESO (mm)
2.8	28~33	350~400	40~60

Microstructure of all weld metal



KCH-615-S produces an austenitic structure. Austenitic structure possesses high toughness and high work-hardening ability.

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of JIE SHENG MACHINERY CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.