



KCH-626-N

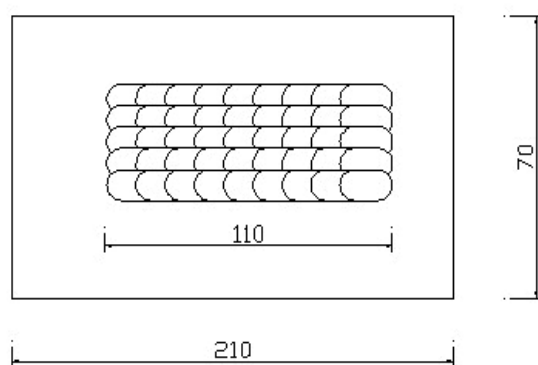
Product Data Sheet

Self-Shielded Flux Cored Wire for Hardfacing

Specification	DIN 8555 : MF 10-GF-60-G
Applications	It is suitable for gyratory crusher mantles and bowls, crusher hammers, crusher cylinders, ripper teeth.
Characteristics	● Weld metal contains primary and eutectic M_7C_3 carbides in an austenitic matrix. ● The chromium-niobium alloy designed to resist gouging abrasive wear with moderate impact. ● Good weldability and almost no slag.
Note on Usage	● Weld metal is unable to be machined, but it can be ground if necessary. ● Preheat temperature is 150~250°C for carbon steel, low alloy steel or cast steel base metal.

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(+)



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- **Hardness of Weld Metal**

Layer	1	2	3
Hardness (HRC)	55~58	57~60	58~62

- **Chemical Composition of Weld Metal**

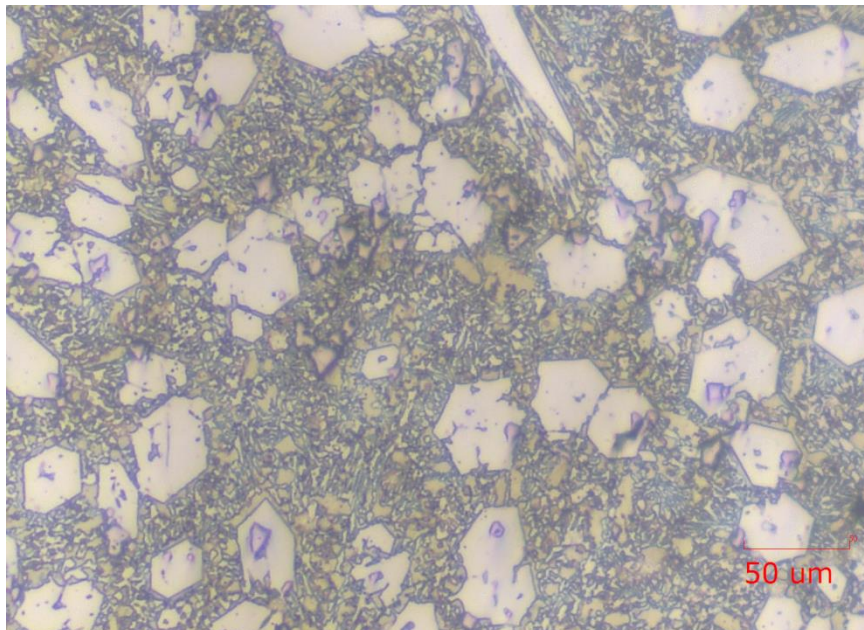
unit: wt%

C	Si	Mn	P	S	Cr	Nb
4.3	1.33	1.58	0.035	0.007	26.4	4.67

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-60CN-O produces coarse primary chromium carbides, fine primary niobium carbide and the eutectic M_7C_3 carbides in an austenitic matrix. It results in a significant improvement in wear performance.

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 Kuang Tai Metal IND 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.

