



FLUX CORE WIRES FOR HARD FACING

Brand Name	Size (mm)	Equivalent Specification	Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal			Characteristics and Applications	Approvals
						C	Si	Mn	P	S	Cr	Mo	Ni	HV	HRC	HS		
K-250HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF2A-C-250 T Fe1	F, H-Fil	CO ₂	DC(+)	0.07	0.50	1.55	0.013	0.010	1.30	-	-	260	24	37	MAG welding wire for metal-to-metal wearing and under layer welding of hard surfacing. Low spatter level, easy slag removal and reduced grinding time after work hardening.	-
K-300HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF2A-C-300 T Fe1	F, H-Fil	CO ₂	DC(+)	0.09	0.68	1.54	0.014	0.011	1.30	-	-	300	30	42	MAG welding wire for hard facing and repairing rollers, shafts and wheels etc. It can be possible to get abrasion resistance with proper preheat and interpass temperature.	-
K-350HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF2A-C-350 T Fe1	F, H-Fil	CO ₂	DC(+)	0.12	0.45	1.37	0.014	0.011	1.30	0.20	-	360	37	50	MAG welding wire with higher hardness for metal-to-metal wear and mild abrasion. Used on transfer rollers and idlers, crane wheels and shafts etc.	-
K-450HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF2A-C-450 T Fe1	F, H-Fil	CO ₂	DC(+)	0.24	0.51	1.20	0.013	0.010	2.00	0.60	-	450	45	61	MAG welding wire for metal-to-metal wearing or abrasion. The weld metal is of martensite. Structure and has stable hardness because it contains carbide forming elements.	-
K-500HT	1.2~1.6	JIS Z 3326 YF3B-C-500	F, H-Fil	CO ₂	DC(+)	0.19	2.06	0.35	0.014	0.012	5.26	0.59	-	510	50	66	K-500HT can be used to weld low carbon, medium carbon, low alloy and manganese steel. It is especially suitable for overlaying thin gauge materials, building up edges, crusher rolls etc.	-
K-600HT	1.2~1.6	JIS Z 3326 YF3B-C-600	F, H-Fil	CO ₂	DC(+)	0.34	2.80	0.50	0.013	0.009	6.50	0.50	-	610	55	73	MAG welding wire produces a deposit which resists metal-to-metal wear and mild abrasion. It can be used for crane wheels, blower blades, bucket lips, dredge parts etc.	-
K-700HT	1.2~1.6	-	F, H-Fil	CO ₂	DC(+)	0.40	3.20	0.60	0.012	0.010	7.00	0.80	W : 0.50	705	60	80	MAG welding wire for heavy abrasion resistance with martensitic structure. It can be used for crane hammers, ore chuter, dozer blades, ripper teeth, bucket lips etc.	-
K-800HT	1.2~1.6	-	F, H-Fil	CO ₂	DC(+)	0.44	3.40	0.55	0.013	0.011	7.50	1.00	W : 0.70	780	63	87	MAG welding wire for heavy abrasion resistance with martensitic structure. It can be used for augers, bucket lips, conveyor screws, blower blades, dozer blades etc.	-
K-CXA-40HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF4A-G-350 T Fe1	F, H-Fil	Ar+2%O ₂	DC(+)	0.05	0.25	0.30	0.014	0.009	12.00	-	4.20	370	38	51	MAG welding wire for metal-to-metal wearing and under layer welding of hard surfacing. It can be used for tractor rollers, trunnions, crane wheels, track rails, idlers etc.	-
K-CXA-41HT	1.2~1.6	JIS Z 3326 EN ISO 14700 YF4A-G-350 T Fe1	F, H-Fil	Ar+2%O ₂	DC(+)	0.05	0.39	0.49	0.012	0.010	12.10	1.10	3.90	370	38	51	MAG welding wire for metal-to-metal wearing abrasion and corrosion resistance. It can be used for tractor rollers, shafts, rollers, valves, track rails, idlers etc.	-

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K-40RT	1.6~3.2	-	F, H-Fil	Ar+20 ~25%CO ₂	DC(+)	0.07	0.57	1.81	0.013	0.010	2.66	1.43	3.33	-	40	-	MAG welding wire for repair and hard facing of hot-rolling forging mold.	-
K-58RT	1.6~3.2	-	F, H-Fil	Ar+20 ~25%CO ₂	DC(+)	0.32	0.87	0.77	0.012	0.011	9.87	2.50	0.11	-	55	-	MAG welding wire for repair and hard facing of hot-rolling forging mold.	-
K-63RT	1.6~3.2	-	F, H-Fil	Ar+20 ~25%CO ₂	DC(+)	0.15	0.94	0.83	0.013	0.009	9.65	1.70	2.00	-	50	-	MAG welding wire for repair and hard facing of hot-rolling forging mold. It is more available to weld in the first layer of hard facing welding on hot-rolling forging mold.	-
K-65RT	1.6~3.2	-	F, H-Fil	Ar+20 ~25%CO ₂	DC(+)	0.24	0.84	0.61	0.012	0.010	9.10	2.50	1.80	-	55	-	MAG welding wire for repair and hard facing of hot-rolling forging mold.	-
K-13CrHT ×EF-200F	2.0~3.2	-	F, H-Fil	-	DC(+)	0.05	0.50	1.50	0.010	0.008	13.80	1.00	3.00	390	40	54	MAG welding wire for repair and hard facing of continuous casting roller.	-
K-13CrNiHT ×EF-200F	2.0~3.2	-	F, H-Fil	-	DC(+)	0.05	0.40	1.20	0.010	0.009	13.00	1.00	4.50	410	42	56	MAG welding wire for repair and hard facing of continuous casting roller.	-

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