



KISWEL K-600HT

Classifications:

JIS Z 3326: YF3B-C-600

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	S	Mo	P
0.34	2.80	0.50	6.50	0.009	0.50	0.013

Description:

- It is designed for welding of metal to metal and underlaying welding of hardfacing
- Typical applications include crane wheels, blower blades, bucket lips, dredge parts etc
- In order to minimize cracking, should obey the preheat and interpass temperature

Typical Mechanical Properties:

HV	Typical Value HRC	HS	Interpass Temperature
610	55	73	200°C

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	CO ₂	180	220	22	25



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