

## Covered Electrode for Heat, Corrosion and Wear Proof Welding

# K T - 1 1 C R

- Standard                    DF4A-B
- Covering                    Low Hydrogen Type
- Tip Color                    End Face: Blue  
                                      Side Face: Red

■ Application

Overlaying for hot and cold shear, liner for turbine, casing for pump, mould, and so on.

■ Features

1. The deposited metal shows martensite structure. As a result, it has excellent crack resistant property and toughness. It also has good heat resistant property. Hence KT-11CR is suitable for overlaying on the tool steel for cold and hot working.

■ Welding Procedures

1. In general, about 150°C preheating is necessary.
2. 50mm bead length is preferable to weld on the hardenable base metal.
3. The electrode should be re-dried for 30~60 minutes at over 300°C before use.

■ Typical Chemical Component of the Deposited Metal (%)

C	Si	Mn	Cr
0.27	0.95	1.45	11.50

■ Typical Hardness of the Deposited Metal as welded

Condition	HV	HRC	HS
Continuous Welding	540~610	52~56	69~75
Preheating and Interpass Temp. 150°C	580~650	54~58	72~78

■ Appropriate Welding Current (AC or DCEP)

Diameter (mm)	3.2	4.0
Length (mm)	350	400
Current (A)	70~110	100~150
Min. Quantity (Kg)	5.0	5.0

Equivalent to wire for MAG welding: MH-13HS  
 Equivalent to electrode for TIG welding: MHP-13T