

AKD017



Deposited metal hardness: HB $\geq$ 53

Description: AKD017 is a basic cast iron edge surfacing electrode with beautiful shape, stable arc, small spatter and easy slag removal. The deposited metal is a martensitic carbide dispersed structure, which has good crack resistance. The weld ment is not preheated before welding, and the deposited metal has no cracks after welding.

Application: It is suitable for surfacing and repair welding of cast iron and alloy cast iron trimming mold edges.

Typical Chemical Composition(%):

	C	Si	Mn	Cr	S	P	—
Actual Result	0.28-0.35	1.00-2.00	0.6-1.5	5.5-7.5	0.04	0.04	—

Recommended welding parameters:

Diameter/ mm	3.2	4.0	—	—
Electrode Length (mm)	350	350	—	—
Welding Current(A)	100-130	130-170	—	—

1. The electrode must be baked at 300-350℃ for 1 hour before welding
2. Rust, oil, moisture and other sundries on the weld ment must be removed before welding