



AKD417

Deposited metal hardness: HB $\geq$ 55

Description: AKD417 is a molybdenum-tungsten-vanadium electrode with low hydrogen sodium coating, and it adopts DC reverse connection. It has good processability, wear resistance and good crack resistance.

Application: It is used for surfacing welding where it is resistant to strong impact and wear, corrosion and cavitation, such as single and double toothed roller crushers, blades, blast furnace bells, etc. It can also be used for surfacing welding of various stamping dies.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Mo	V	W	Other
Requirement	0.5-0.9	0.8	0.6	0.030	0.040	5.0-9.5	0.8-1.3	1.0-2.5	1.00

Recommended welding parameters:

Diameter/ mm	2.5	3.2	4.0	—
Electrode Length (mm)	300	350	350	—
Welding Current (A)	70-80	90-100	130-150	—

1. The electrode must be baked at 360C for 1 hour before welding.
2. The workpiece must be preheated to above 300C before welding to avoid cracking.