

AKD58

HRC=58

Description: Stable arc and easy slag removal during cladding; soft and stable arc, low spatter, beautiful shaping, good slag removal, low fume and excellent welding process performance.

Application: Suitable for welding the surfaces of various worn parts, such as gears, buckets, mining machinery, etc..

Typical Chemical Composition(%):

	C	Cr	Mo	Mn	Si	P	S
Actual Result	0.50	5.80	0.60	0.95	0.50	0.020	0.005

Recommended welding parameters:

Diameter/ mm	Volt	Amp	mm	l/min
1.2mm	28-30	250-280	18-25	20-25
1.6 mm	30-32	280-320	18-25	20-25

Notes on Usage:

1、 Protective gas: CO₂ .

2、 Large workpieces should be preheated to around 250°C before overlay. welding and preferably maintained at an interlayer temperature of 250-350°C.