



AKD717

Deposited metal hardness: HRC≥60

Description: The AKD717 tungsten carbide surfacing electrode is made of H08A steel strip, rolled into an "O" shape, and the cast tungsten carbide with a content of more than 60% of the weight of the welding core is used as the welding core. Tungsten carbide transition C and W. The arc is stable, DC welding is suitable, and a small current is used.

Application: Suitable for surfacing mechanical parts that are resistant to strong rock wear, such as the claw back of the three-cone drill bit, blower blades, powerful coal mining drums, sugar press rolls, concrete mixer blades, etc.

Typical Chemical Composition(%):

Element	C	Si	Mn	Cr	Ni	Mo	W	Other
Requirement	1.5-4.0	4.0	3.0	3.0	3.0	7.0	50.0-70.0	3.00

Recommended welding parameters:

Diameter/ mm	3.2	4.0	—	—
Electrode Length (mm)	350	350	—	—
Welding Current(A)	120-160	140-190	—	—

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.