

AKD948



Deposited metal hardness: HRC 62-66

Description: AKD948 is a graphite-type coated high-carbon high-chromium cast iron surfacing electrode. The electrode coating has excellent electrical conductivity, and the arc is stable without spatter. There is very little mineral slag forming agent in the coating, and there is basically no need to remove slag during welding, and the efficiency of deposited metal is as high as 85%. The surfacing metal has high hardness, excellent wear resistance and cavitation resistance.

Application : Used for surfacing welding to bear a certain impact load and require high abrasive wear resistance, such as wear-resistant plates and wear-resistant rings (commonly known as eye plates) for concrete pump Spipe valves, hammer mills Surfacing welding of hammer heads, material distribution discs, sintering crusher gear rollers, etc..

Typical Chemical Composition(%):

	C	Cr	Other	—	—	—	—	—
Requirement	4.0-5.0	25.0-28.0	8.0-13.5	—	—	—	—	—

Recommended welding parameters:

Diameter/ mm	3.2	4.0	5.0	—
Electrode Length (mm)	350	400	400	—
Welding Current(A)	90-120	150-180	180-210	—

1. The electrode must be baked at 250°C for 1 hour before welding.
2. Rust and oil stains on the surface of the workpiece should be cleaned before welding.
3. When welding, care should be taken to fully melt the coating to ensure the effective transition of the alloy.