

AKDF-2B



Deposited metal hardness: HRC≥48

Description: AKDF-2B is a low-hydrogen coating welding electrode, and the deposited metal has good wear resistance, heat resistance, corrosion resistance and crack resistance. Surfacing welding process is simple, no preheating before welding, no heat treatment after welding; but for high-carbon or high-alloy very large parts must be preheated to 100-200C before welding, excellent crack resistance, surfacing hard alloy layer can be machinable. Use DC reverse connection.

Application: Used for surfacing welding of parts affected by water, steam and gas with working temperature below 500C: such as surfacing welding of 35# steel, 45# steel, low alloy steel, mixer blade, blast furnace bell, and sealing surface of high and medium pressure valves and fixes.

Typical Chemical Composition(%):

	C	Cr	Other	—	—	—	—	—
Requirement	0.25	12.0-16.0	≥8	—	—	—	—	—

Recommended welding parameters:

Diameter/ mm	3.2	4.0	5.0	—
Electrode Length (mm)	350	350	400	—
WeldingCurrent(A)	120-160	140-190	180-210	—

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.
3. The thickness of the surfacing hard alloy layer must be ≥ 5mm.
4. Continuous welding must be applied during welding.