

Mechanical Properties

Hardness As Welded	After Working
250 - 300 (HB)	400 - 450 (HB)

Features and Applications

- Kavtam is Cobalt, Chromium, Manganese and Silicon alloyed manual stick electrode and used for hardfacing work pieces which are subjects to severe cavitation and erosion
- The weld deposit is also resistant to corrosion, cavitation and erosion at high temperatures.
- Main applications are hardfacing of hydraulic turbines, pumps, valves, casings, rotors
- The hardness after welding is 250-300HB and after workhardened is approximately 450HB
- Requirement of re-drying for 2 hours at 300°C

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3030100090	3.20 x 350	1/8 x 14"	90 - 130	4930

Approvals: SEPRO