

# CH-80

For soil abrasion

JIS Z3251 DF3C-600-B  
DIN E6-60

## Applications

Hard-surfacing of cutter knives, liner, mixer-blades and casings.

## Characteristics

CH-80 is a low hydrogen type electrode depositing weld metal of uniform martensite structure.

It is suitable for soil abrasion.

Machining is not applicable as welded.

## Notes on usage

- (1) Preheat at 150°C and over in general.
- (2) It is desirable to postheat at about 600°C.
- (3) In case of multi-layer build-up welding or welding mother plates with hardening property, under-lay with low hydrogen type electrodes for mild steel.
- (4) Dry the electrodes at 300~350°C for 30~60 minutes before use.

## Typical chemical composition of weld metal (%)

C	Mn	Si	Cr	Mo
0.58	1.77	0.69	3.41	1.01

## Typical hardness of weld metal

Hv	H <sub>R</sub> C
630	57

## Size & recommended current range (AC or DC +)

Dia. (mm)	3.2	4.0	5.0	6.0	
L (mm)	350	400	400	450	
Amp.	F	90-130	140-180	190-240	220-300

• Tip Color : Blue