

SK OA 2010

DIN 8555 : MF 10-GF-55-G

DESCRIPTION

1

Open-arc wire depositing a medium Chromium carbide alloy designed to resist grinding abrasive wear with medium impact.

SUITABLE FOR

2

Final overlay on gyratory crusher mantles, augers, crusher hammers and crusher rollers, palm kernels expeller screws.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Fe
All Weld	3.50	1.3	1.7	16.5	BAL

TYPICAL MECHANICAL PROPERTIES

4

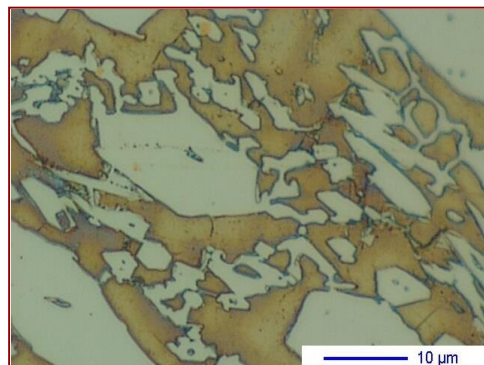
Hardness as welded

56 HRC

GENERAL CHARACTERISTICS

5

- Microstructure Interdendritic eutectic carbides in an austenitic matrix
- Machinability Grinding only
- Oxy-acetylene cutting Cannot be flame cut
- Deposit thickness 10 to 12 mm in 2 to 3 layers
- Metal cored



The information about the products contained in the data sheets are based on intensive tests and careful investigations. However we can't assume any form of liability concerning the exactness of it. The information may be changed or updated without previous notice. The user is invited to test the product with regard to his own application and responsibility.

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WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Flux-Rate	Gas Rate	Psi	Travel Speed	Spray Dist	Article Code	Packaging	Availability
1,2	120-150	26-30	35-40						29347	Spool 15 KG	On request
1,6	180-200	26-30	35-40						29348	Spool 15 KG	Standard
2,4	250-300	26-30	35-40						45823	Autopack 150 KG	On request with minimal quantity
2,8	300-350	26-30	35-40						29351	Spool 15 KG	On request with minimal quantity

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