

SK 242-0

open arc flux cored wire

DIN 8555								
MF 1-GF-4	10-P							
Character	istics							
	wire designed vear with imp		lding and hard	surfacing of C	arbon steel	parts subj	ected to	
Microstructure:		Bair	Bainite + Martensite					
Machinability:		Goo	Good					
Oxy-acetylene cutting:		Can	Cannot be flame cut					
Deposit thickness:		Depends upon application and procedure used						
Field of u	se			-	_	-	-	
		nd idlers,	shafts, cylinde	rs, mine car w	heels, crane	wheels.	-	
		nd idlers,	shafts, cylinde	rs, mine car w	heels, crane	wheels.	_	
Crawler tra Typical ar	actor rollers a	nd idlers,	shafts, cylinde Si	rs, mine car w Cr	heels, crane Ti	wheels.	Fe	
Crawler tra Typical ar C	actor rollers a nalysis in %	nd idlers,				wheels.	Fe balance	
Crawler tra Typical ar C 0.11	actor rollers a nalysis in % Mn		Si	Cr	Ti	wheels.	-	
Crawler tra Typical ar C 0.11 Typical m	actor rollers a nalysis in % Mn 0.6	operties	Si	Cr	Ti	wheels.	-	
Crawler tra Typical ar C 0.11 Typical m Hardness	actor rollers a nalysis in % Mn 0.6 echanical pr	operties	Si 0.6	Cr	Ti	wheels.	-	
Crawler tra Typical ar C 0.11 Typical m Hardness Recomme	actor rollers a halysis in % Mn 0.6 echanical pr as welded: 40	operties OHRC	Si 0.6 eters	Cr	Ti 0.9		-	
Crawler tra Typical ar C 0.11 Typical m Hardness Recomme Wire diam	actor rollers a nalysis in % Mn 0.6 echanical pr as welded: 40 ended weldir	operties OHRC	Si 0.6 eters age [A]	Cr 2.4	Ti 0.9		balance Put [mm]	
Crawler tra Typical ar C 0.11 Typical m Hardness Recomme Wire diam 1.2	actor rollers a nalysis in % Mn 0.6 echanical pr as welded: 40 ended weldir	operties DHRC Dag parame Ampera	Si 0.6 eters age [A] 50	Cr 2.4 Voltage [V]	Ti 0.9	Stick-O	balance put [mm]	
Crawler tra Typical ar C 0.11 Typical m Hardness Recomme	actor rollers a nalysis in % Mn 0.6 echanical pr as welded: 40 ended weldir	operties DHRC DB parame Ampera 120 – 1	Si 0.6 eters age [A] 50 00	Cr 2.4 Voltage [V] 26 – 30	Ti 0.9	Stick-O 35 – 40	balance but [mm]	