SK 402-O

open arc flux cored wire

Classifications

DIN 8555

MF 8-GF-150/400-KPZ

Characteristics

Austenitic alloy type 18Cr8Ni7Mn recommended for build up and buffer layer prior to hardfacing. It can also be used for joining of dissimilar metals.

Microstructure:	Austenite
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	As required

Field of use

Joining of wear plates on shovel buckets, railways and tramway lines, press rams, joining stainless steels to carbon manganese steels, building up and buttering before hardfacing, welding of 14 % Mn steels, armour and hard to weld steels.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0.09	6.0	0.9	18.0	7.8	balance

Typical mechanical properties

Hardness as welded: 160 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	120 – 150	26 – 30	35 – 40
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40