SK 430 Mo-SA

SAW cored wire

Classifications

DIN 8555

UP 6-GF-300-C

Characteristics

Alloy depositing a ferritic steel containing 17 % Chromium enhanced with Molybdenum addition designed to resist corrosion at high temperatures, particularly in presence of sulphurous gas.

Microstructure:	Ferrite and few martensite
Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Welding flux:	Record SA, Record SK

Field of use

Continuous casting rollers, valves, steam and gas turbine parts, valve seats.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.25	1.0	0.6	17.9	1.0	balance

Typical mechanical properties

Hardness as welded: 260 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50