SK A44-O

open arc metal cored wire

Classifications

DIN 8555

MF 10-GF-60-G

Characteristics

CrNb alloy with addition of Molybdenum, Tungsten and Vanadium designed to resist high stress and gouging abrasion with moderate impact.

Microstructure:	Austenitic matrix with primary & eutectic carbides and nodular Nb carbides
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	2 to 3 layers maximum

Field of use

Wear plates, blast furnace burden area, chutes.

Typical analysis in %

C	Mn	Si	Cr	Mo	Nb	W	V	Fe
5.2	0.9	0.5	19.0	1.2	5.1	1.0	1.0	balance

Typical mechanical properties

Hardness as welded: 62 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	27 – 30	35 – 40