SK A46-O

open arc metal cored wire

Classifications

DIN 8555

MF 10-GF-60-GZ

Characteristics

Chromium-Molybdenum-Cobalt alloy designed to resist high stress grinding abrasive wear at service temperature up to 650 °C.The deposit will readily show stress relief cracks. The deposits can be heat treated at 900 °C and then quenched in water to give a hardness of 67HRC.

Microstructure:	Complex 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

Field of use

Ore crushers, fan blades, pump casing, sinter plant parts, back-up plates in steel grit blasting equipment.

Typical analysis in %

C	Mn	Si	Cr	Mo	Co	Fe
4.7	0.2	1.0	20.7	5.0	8.8	balance

Typical mechanical properties

Hardness as welded: 61 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40