

## Classifications

DIN 8555

MF 6-GF-200-K

## Characteristics

The SK Hydrocav is gas shielded metal cored wire suitable for surfacing of parts (especially soft martensitic 13/4 stainless steels) where high resistance to cavitation, corrosion, pressure and impact is required. Work-hardenable alloy.

Microstructure:	Austenitic type
Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Shielding gas:	Argon 98% + CO <sub>2</sub> 2%

## Field of use

Turbine blades, pumps.

## Typical analysis in %

C	Mn	Si	Cr	Co	N	Fe
0,17	8,5	1,8	21,0	12,0	0,25	balance

## Typical mechanical properties

Hardness as welded: 220 HB	Hardness after work hard: 40 HRC
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## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-250	20-31	20 max.	15-18