SK STELKAY 25-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 20-GF-200-STZ

Characteristics

Cobalt base alloy providing excellent resistance to metal-to-metal wear, thermal shocks, oxidation in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.

Microstructure:	Solution of the austenitic type
Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98 % + Oxygen 2% or Argon 100%

Field of use

Hot working tools, forging hammers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Co	W	Fe
0,01	0,8	0,4	20,2	10,0	balance	13,0	3,5

Typical mechanical properties

Hardness as welded: 195 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18