SK 768-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 5-GF-350-C

Characteristics

Alloy depositing a ferritic-martensitic steel containing 13% Chromium, 5% Nickel and 2% Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure:	Martensite + Ferrite + residual austenite
Machinability:	Good with carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98% + Oxygen 2%

Field of use

Surfacing of continuous casting rollers of very small diameters (<150 mm).

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0,02	0,3	0,3	14,5	6,3	2,5	balance

Typical mechanical properties

Hardness as welded: 34 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	200-250	24-28	20 max.	15-18