

SK 089-O

DIN 8555 : MF 2-GF-50-G

DESCRIPTION

1

Alloy specifically designed for the hot repair of ingot moulds.

SUITABLE FOR

2

Hot repair of ingot moulds.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Fe	Ti
All Weld	3.40	0.3	1.7	Bal.	0.2

TYPICAL MECHANICAL PROPERTIES

4

Hardness as welded

50 HRC

GENERAL CHARACTERISTICS

5

- Microstructure: Lamellar grey cast iron
- Machinability: Good with metallic carbide tipped tools
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: As required if interpass temperature (min 300°C) is correctly applied

WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
2,8	300-350	26-30	35-40	31734	Coil 25 Kg	On request

The information about the products contained in the data sheets are based on intensive tests and careful investigations. However we can't assume any form of liability concerning the exactness of it. The information may be changed or updated without previous notice. The user is invited to test the product with regard to his own application and responsibility.