

SK 19.17.5L-O

DIN 8555 : MF 9-GF-150-C

DESCRIPTION

1

Self shielded flux cored wire depositing a 19%Cr-17%Ni-5% Mo with a low Carbon. The structure of the deposited weld metal is entirely austenitic without ferrite.

SUITABLE FOR

2

Corrosion resistant applications, repair of galvanisation tanks.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Ni	Mo	Fe
All Weld	0.02	1.5	0.8	19.50	16.80	4.9	Bal.

TYPICAL MECHANICAL PROPERTIES

4

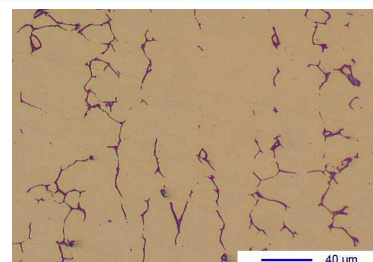
Hardness as welded

170 HB

GENERAL CHARACTERISTICS

5

- Microstructure: Fully austenitic
- Machinability: Good
- Oxy-acetylene cutting: Not possible
- Deposit thickness: Depends upon application and procedure used



WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-220	26-30	35-40	46616	Autopack 250 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	46618	Autopack 250 Kg	On request with minimal quantity

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.