

SK 218-O

DIN 8555 : MF 7-GF-200-KP
ASME IIC SFA 5.21 : ERC FeMn-G

DESCRIPTION

1

Self shielded flux cored wire depositing an austenitic alloy designed for rebuilding of 14% Manganese steel parts.

SUITABLE FOR

2

Crusher cylinders, crusher hammers, impactor bars.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Ni	Fe
All Weld	0.90	14.0	0.6	3.50	0.40	Bal.

TYPICAL MECHANICAL PROPERTIES

4

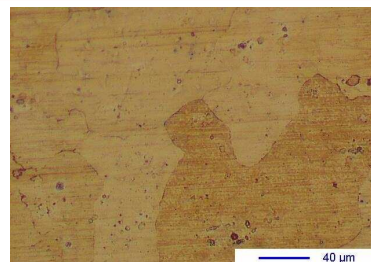
Hardness as welded

200 HB

GENERAL CHARACTERISTICS

5

- Microstructure: Austenite
- Machinability: Good with metallic carbide tipped tools
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: As required
- Flux cored



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.

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WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29306	Spool 15 Kg	Standard
2,4	250-300	26-30	35-40	29308	Spool 15 Kg	On request
2,8	300-350	26-30	35-40	29309	Spool 15 Kg	On request
2,8	300-350	26-30	35-40	37497	Coil 25 Kg	On request with minimal quantity

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