

SK 219-O

DIN 8555 : MF 7-GF-200/450-KP

DESCRIPTION

1

Designed to deposit a fully austenitic alloy in a single layer on Carbon steel parts.

SUITABLE FOR

2

Tramway and railway rails, crossovers, crossing frogs and curves.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Fe
All Weld	1.20	21.0	0.3	5.00	Bal.

TYPICAL MECHANICAL PROPERTIES

4

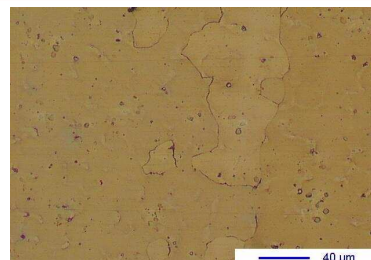
Hardness as welded

220 HB

GENERAL CHARACTERISTICS

5

- Microstructure Austenite
- Machinability Good with carbides tipped tools
- Oxy-acetylene cutting Not possible
- 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

6

Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	180-220	26-30	35-40	29311	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	29312	Spool 15 Kg	On request with minimal quantity
2,8	300-350	28-30	30-35	29313	Spool 15 Kg	On request with minimal quantity
2,8	300-350	28-30	30-35	41657	Coil 25 Kg	On request with minimal quantity
3,2	325-450	28-30	30-35	NA	Coil 25 Kg	On request with minimal quantity

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