

SK 242-O

DIN 8555 : MF 1-GF-40-P

DESCRIPTION

1

Open-arc wire designed for rebuilding and hard surfacing of Carbon steel parts subjected to adhesive wear with impacts.

SUITABLE FOR

2

Crawler tractor rollers and idlers, shafts, cylinders, mine car wheels, crane wheels.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Fe	Ti
All Weld	0.11	0.7	0.7	2.40	Bal.	0.9

TYPICAL MECHANICAL PROPERTIES

4

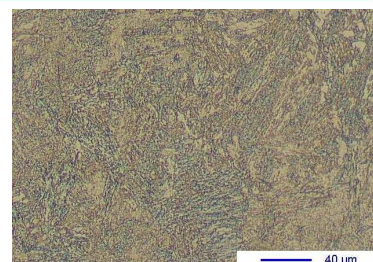
Hardness as welded

40 HRC

GENERAL CHARACTERISTICS

5

- Microstructure: Bainite + Martensite
- Machinability: Good
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: Depends upon application and procedure used
- 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
1,2	120-150	26-30	35-40	NA	Spool 15 Kg	On request with minimal quantity
1,6	180-200	26-30	35-40	29282	Spool 15 Kg	Standard
2,4	250-300	26-30	35-40	NA	Spool 15 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	29285	Spool 15 Kg	On request
2,8	300-350	26-30	35-40	40421	Coil 25 Kg	Standard

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