

SK 252-O

DIN 8555 : MF 1-GF-45-G

DESCRIPTION

1

Open-arc wire designed to deposit an alloy resistant to abrasive wear with impacts.

SUITABLE FOR

2

Crawler tractor rollers and idlers, crane wheels, shovel bucket rollers, shafts.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Fe	Ti
All Weld	0.17	1.4	0.7	2.80	Bal.	1.0

TYPICAL MECHANICAL PROPERTIES

4

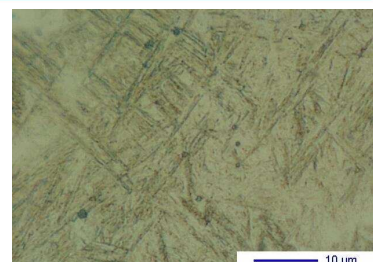
Hardness as welded

44 HRC

GENERAL CHARACTERISTICS

5

- | | |
|-------------------------|---|
| ▪ Microstructure | Martensite |
| ▪ Machinability | Good with metallic carbides or Boron Nitride tipped tools |
| ▪ 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

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Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29287	Spool 15 Kg	On request with minimal quantity
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	NA	Spool 15 Kg	On request with minimal quantity

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