

## SK 255-O SP

DIN 8555 : MF 10-GF-60-G  
ASME IIC SFA 5.21 : FeCr-A9

### DESCRIPTION

1

Open-arc metal cored wire designed to deposit a metal resistant to high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks

### SUITABLE FOR

2

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

|          | C    | Mn  | Si  | Cr    | Fe   |
|----------|------|-----|-----|-------|------|
| All Weld | 4.60 | 0.7 | 1.3 | 26.20 | Bal. |

### TYPICAL MECHANICAL PROPERTIES

4

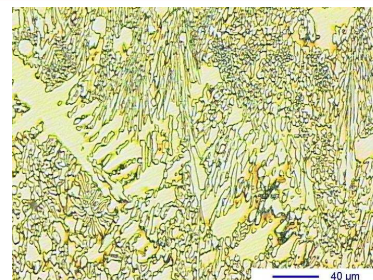
Hardness as welded

60 HRC

### GENERAL CHARACTERISTICS

5

- Microstructure: Primary carbides and eutectic carbides in an austenitic matrix
- Machinability: Grinding only
- Oxy-acetylene cutting: Cannot be flame cut.
- Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers
- Metal 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<br>[mm] | Current<br>[A] | Voltage<br>[V] | Stick-<br>Out | Article<br>code | Packaging       | Availability                     |
|------------------|----------------|----------------|---------------|-----------------|-----------------|----------------------------------|
| 2,8              | 300-350        | 26-30          | 35-40         | 41865           | Coil 25 Kg      | On request with minimal quantity |
| 2,8              | 300-350        | 26-30          | 35-40         | 29652           | Autopack 150 Kg | On request with minimal quantity |
| 2,8              | 300-350        | 26-30          | 35-40         | 29653           | Autopack 250 Kg | On request with minimal quantity |

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