soudokay

SK 256-O

DIN 8555 : MF 10-GF-65-G

1 DESCRIPTION

High Chromium carbide alloy designed to resist high stress grinding abrasion coupled with low impact. The deposits will readily show stress relief cracks.

2 SUITABLE FOR

Refurbishment of Ni-Hard coal pulverizing rollers, shovel bucket teeth and lips handling sand, pipes and bends.

3 TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

	C	Mn	Si	Cr	Fe
All Weld	5.50	1.2	1.2	25.70	Bal.

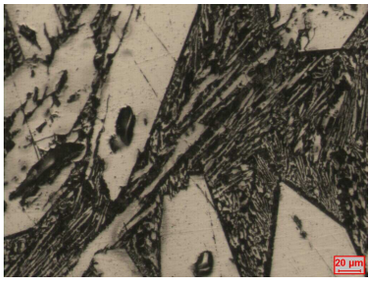
4 TYPICAL MECHANICAL PROPERTIES

Hardness as welded

63 HRC

5 GENERAL CHARACTERISTICS

- Microstructure — Primary Chromium carbides (70%) and eutectic carbides in an austenitic matrix
- Machinability — Grinding only
- Oxy-acetylene cutting — Cannot be flame cut
- Deposit thickness — 10 to 12 mm maximum in 2 to 3 layers
- Metal cored



Böhler Welding GROUP

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WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29378	Spool 15 Kg	Standard
2,4	250-300	26-30	35-40	29379	Spool 15 Kg	On request
2,4	250-300	26-30	35-40	47145	Autopack 250 Kg	On request
2,8	300-350	26-30	35-40	41879	Autopack 250 Kg	On request with minimal quantity

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