

SK 256 Mn-O

DIN 8555 : MF 10-GF-65-G

DESCRIPTION

1

Open-arc metal cored wire depositing an High Chromium carbide alloy designed to resist high stress grinding abrasion coupled with low impact. The deposits will readily stress relief crack.

SUITABLE FOR

2

Wear plates, pipes, shovel bucket teeth and lips handling sand.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

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	C	Mn	Si	Cr	Fe
All Weld	6.20	2.5	1.4	25.00	Bal.

TYPICAL MECHANICAL PROPERTIES

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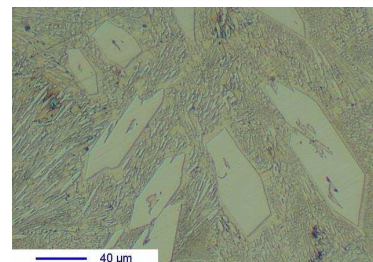
Hardness as welded

63 HRC

GENERAL CHARACTERISTICS

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- Microstructure: Primary Chromium carbides (70%) in an eutectic 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



WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
2,8	300-550	26-34	35-40	41462	Coil 25 Kg	On request with minimal quantity
3,2	400-750	26-34	35-40	41888	Autopack 250 Kg	On request with minimal quantity

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.