

## SK 258 NBC-O

DIN 8555 : MF 6-GF-60-G

### DESCRIPTION

1

Open-arc flux-cored wire designed to deposit a crack-free martensitic alloy.

### SUITABLE FOR

2

Inter-particles crusher rollers.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Nb	W	Fe
All Weld	1.40	0.7	1.2	5.30	8.50	1.5	Bal.

### TYPICAL MECHANICAL PROPERTIES

4

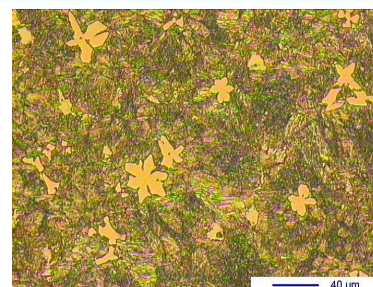
Hardness as welded

57 HRC

### GENERAL CHARACTERISTICS

5

- Microstructure Martensite, little residual austenite and dispersed NbC carbides
- Heat treatment & precautions Preheating temperature 250°C
- Interpass temperature 300°C
- Stress-relieving 500°C for 6 to 8 hours
- Buffer layer On 34 CrNiMo6 and 18 CrNiMo6 one layer of Soudocore D-SA (Soudor D) is recommended.
- Machinability Grinding only
- Oxy-acetylene cutting Cannot be flame cut.
- Deposit thickness Up to 4 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.

## SK 258 NBC-O

DIN 8555 : MF 6-GF-60-G

### WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
2,0	200-250	26-30	35-40	55450	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	41661	Coil 25 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	41663	Coil 25 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	53984	Autopack 250 Kg	On request with minimal quantity
3,2	350-400	26-30	35-40	53986	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.