

## SK 299-O

DIN 8555 : MF 10-GF-65-GZ

### DESCRIPTION

1

Flux-cored wire for open arc welding designed to surface parts subject to high stress grinding abrasion without impact at higher temperature (up to 650°C).

### SUITABLE FOR

2

Sinter plant bars, Chutes, conveyor screws, mixers, shovel bucket parts working in sand Clinker crusher.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Nb	V	Fe	B
All Weld	4.90	0.3	1.0	11.30	6.80	6	Bal.	0.7

### TYPICAL MECHANICAL PROPERTIES

4

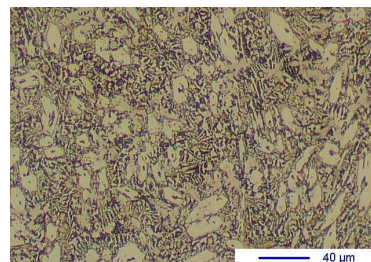
Hardness as welded

64 HRC

### GENERAL CHARACTERISTICS

5

- Microstructure: Austenitic matrix with complex carbides
- Machinability: Grinding only
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: 8 to 10 mm 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

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Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	46209	Spool 15 Kg	On request
2,4	250-300	26-30	35-40	52500	Spool 15 Kg	Standard
2,8	300-350	26-30	35-40	51694	Spool 15 Kg	Standard

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