

SK 309-O

DIN 8555 : MF 9-GF-150

DESCRIPTION

1

Open-arc wire with slag depositing a 23% Chromium 12% Nickel composition suitable for joining dissimilar metals and as buffer layer prior to hard overlays.

SUITABLE FOR

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Stainless steel cladding on carbon steels, buffer layers on difficult to weld steels, Corrosion resistant overlays on rail heads submitted to corrosive action.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Ni	Fe
All Weld	0.04	1.2	0.9	23.50	12.20	Bal.

TYPICAL MECHANICAL PROPERTIES

4

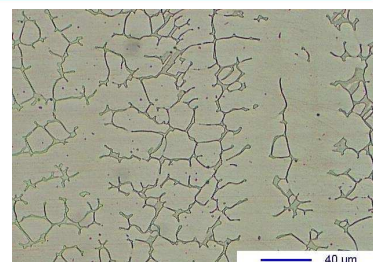
Hardness as welded

170 HB

GENERAL CHARACTERISTICS

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- Microstructure: Austenite + ferrite
- Machinability: Good
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: No restriction
- Flux cored



WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-220	26-29	35-40	29460	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-29	35-40	NA	Spool 15 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.