

## SK 322-O

DIN 8555 : MF 3-GF-55-T

### DESCRIPTION

1

Open-arc cored wire designed to deposit a hypereutectoid steel alloyed with Nickel-Borium. The wire produces a slag.

### SUITABLE FOR

2

Economical hardfacing with a rather good resistance to abrasion, specifically used for civil engineering equipments.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Ni	Fe	Al	B
All Weld	1.90	0.6	0.5	1.20	3.30	Bal.	1.2	0.4

### TYPICAL MECHANICAL PROPERTIES

4

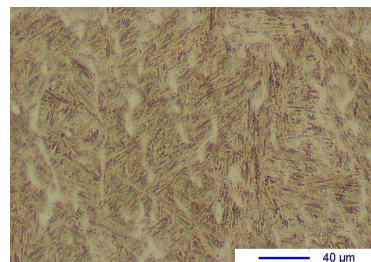
Hardness as welded

55 HRC

### GENERAL CHARACTERISTICS

5

- Microstructure: Martensitic matrix with carbo-borides
- Machinability: Good with cubic Boron Nitride tipped tools
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: Depends upon application and procedure used



### WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-220	26-30	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.