soudokay

SK 402-O

DIN 8555 : MF 8-GF-150/400-KPZ

1 DESCRIPTION

Austenitic alloy type 18Cr8Ni7Mn designed for joining dissimilar metals and for buffer layer deposits prior to hardfacing.

2 SUITABLE FOR

Joining of wear plates on shovel buckets, rebuilding of rails, press rams, tramways rail bends.

3 TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

	C	Mn	Si	Cr	Ni	Fe
All Weld	0.09	6.0	0.9	18.00	7.80	Bal.

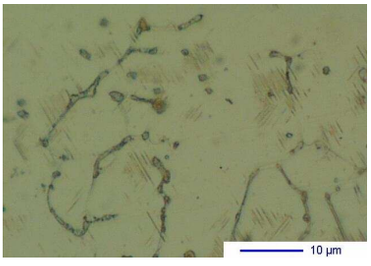
4 TYPICAL MECHANICAL PROPERTIES

Hardness as welded

160 HB

5 GENERAL CHARACTERISTICS

- Microstructure — Austenite
- Machinability — Good with metallic carbide tipped tools
- Oxy-acetylene cutting — Cannot be flame cut
- Deposit thickness — As required
- Flux 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.

Böhler Welding GROUP

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Revision : 200507271123

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WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,4	170-190	26-30	35-40	41359	Spool 15 Kg	On request with minimal quantity
1,6	180-200	26-30	35-40	29451	Spool 15 Kg	Standard
2,0	200-250	26-30	35-40	29453	Spool 7,50 Kg	On request
2,0	200-250	26-30	35-40	29454	Spool 15 Kg	On request
2,4	250-300	26-30	35-40	29455	Spool 15 Kg	Standard
2,8	300-350	26-30	35-40	29456	Spool 15 Kg	On request
2,8	300-350	26-30	35-40	41385	Coil 25 Kg	On request

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