

## SK 502-O

DIN 8555 : MF 10-GF-55-G

### DESCRIPTION

1

Open-arc wire depositing a medium Chromium carbide alloy designed to resist grinding abrasive wear with medium impact.

### SUITABLE FOR

2

Final overlay on gyratory crusher mantles, augers, crusher hammers and crusher rollers, palm kernels expeller screws.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	V	Fe
All Weld	3.60	0.8	1.1	29.00	0	Bal.

### TYPICAL MECHANICAL PROPERTIES

4

Hardness as welded

57 HRC

### GENERAL CHARACTERISTICS

5

- Microstructure: Eutectic carbides in an austenitic matrix
- Machinability: Grinding only
- Oxy-acetylene cutting: Cannot be flame cut.
- Deposit thickness: 10 to 12 mm in 2 to 3 layers
- Metal cored

### WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29433	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.