

SK 642-0

	DESCRIPTION		1
	Open-arc hardsurfacing flux-c	cored wire	
I	SUITABLE FOR		2
	Undercarriage rollers and Idle	ers, shovel teeth, shear blades.	
I	TYPICAL CHEMICAL ANAL	YSIS (WEIGHT %)	3
	C Mn All Weld 0.25 0.3	Si Cr Mo V Fe 0.8 4.80 3.2 1 Bal.	
I	TYPICAL MECHANICAL PF	ROPERTIES	4
	Hardness as welded 51 HRC		
I	GENERAL CHARACTERIS	TICS	5
	 Microstructure Machinability Oxy-acetylene cutting Deposit thickness Metal cored 	Martensite Grinding only Flame cut is difficult Depends upon application and procedure used	
I	WELDING PARAMETERS	& ECONOMICAL DATA	6

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.



 | SOUDOKAY SA | RUE DE L'YSER 2 | B-7180 SENEFFE | BELGIUM | soudokay @soudokay.be | www.soudokay.com

 | SALES: T +32 (0)64 51 02 25
 | LOGISTICS: T +32 (0)64 51 02 10
 | FINANCE: T +32 (0)64 52 00 30

 F +32 (0)64 51 02 21
 F +32 (0)64 51 02 19
 F +32 (0)64 52 00 31