soudokay

SK 674-O

DIN 8555 : MF 10-GF-60

1 DESCRIPTION

Chromium-Niobium alloy with addition of Molybdenum, Tungsten and Vanadium designed to resist high stress grinding abrasion and solid erosion at temperatures up to 600 - 650° C.

2 SUITABLE FOR

Wear plates, fan blades, screens, blast furnace burden area, chutes.

3 TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

	C	Mn	Si	Cr	Mo	Nb	W	V	Fe
All Weld	5.40	0.2	0.8	22.50	2.9	6.20	1.2	0	Bal.

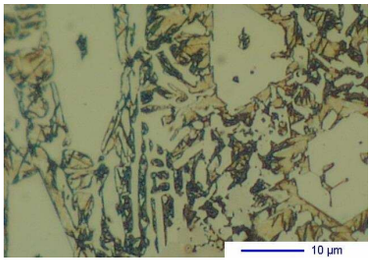
4 TYPICAL MECHANICAL PROPERTIES

Hardness as welded

61 HRC

5 GENERAL CHARACTERISTICS

- Microstructure — Complex 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



Böhler Welding GROUP

| 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 F +32 (0)64 51 02 21 | LOGISTICS: T +32 (0)64 51 02 10 F +32 (0)64 51 02 19 | FINANCE: T +32 (0)64 52 00 30 F +32 (0)64 52 00 31

Revision : 200508171130

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WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-200	26-29	35-40	54216	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-29	35-40	29414	Spool 15 Kg	On request with minimal quantity
2,8	300-350	26-29	35-40	40428	Coil 25 Kg	On request
2,8	300-350	26-29	35-40	29665	Autopack 250 Kg	On request with minimal quantity

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