

SK 900-O

DIN 8555 : MF 21-GF-65-G

DESCRIPTION

1

Cored wire containing about 60 % Tungsten carbide particles. The composition and particle size have been optimized to provide the best combination of toughness and wear resistance. The deposits will readily show stress relief cracks.

SUITABLE FOR

2

Bucked teeth for wheel-bucked excavators in phosphates mines, concrete mixer blades, brick and clay mill augers, crusher rollers, wood chipper spouts and bed knives.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	W	Fe
All Weld	2.90	0.5	0.4	5.80	42.0	Bal.

TYPICAL MECHANICAL PROPERTIES

4

Hardness as welded

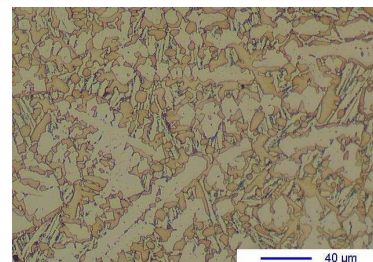
63 HRC

tungsten carbides hardness : about 3000 HV

GENERAL CHARACTERISTICS

5

- Microstructure 35% Tungsten carbides
30% Iron - Tungsten carbides
35% austenite + martensite
- Machinability Grinding only
- Deposit thickness 1 to 2 layers maximum
- Metal 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.

WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	125-250	19-24	35-40	29474	Spool 15 Kg	Standard
2,0	140-300	19-24	35-40	29475	Spool 15 Kg	Standard
2,4	150-350	19-24	35-40	29476	Spool 15 Kg	Standard
2,4	150-350	19-24	35-40	41413	Coil 25 Kg	On request with minimal quantity
2,8	150-350	19-24	35-40	29477	Spool 15 Kg	On request with minimal quantity

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