

SK GS-O

DIN 8555 : MF 2-GF-G

DESCRIPTION

1

Alloy specifically designed for the hot welding of black-heart malleable, ferritic, ferritic-pearlitic and pearlitic SG cast irons

SUITABLE FOR

2

Repair of casting defects, hot welding of cast irons

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Fe
All Weld	2.20	0.3	2.6	Bal.

TYPICAL MECHANICAL PROPERTIES

4

GENERAL CHARACTERISTICS

5

- Microstructure SG cast iron
- Heat treatment & precautions Preheat and Interpass temperature : 450°C
- PWHT of 1h at 850°C is recommended to achieve optimum microstructure
- Machinability Good with carbide tipped tools
- Oxy-acetylene cutting Not applicable
- Deposit thickness Depends upon application and procedure used
- 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.

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WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick- Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29440	Spool 15 Kg	On request with minimal quantity
2,0	200-250	26-30	35-40	49412	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	29441	Spool 15 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	29442	Spool 15 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	41287	Coil 25 Kg	On request with minimal quantity

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