

## SK GS-O SP

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	Ni	Fe
All Weld	3.20	0.3	3.2	0.30	Bal.

### TYPICAL MECHANICAL PROPERTIES

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### GENERAL CHARACTERISTICS

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- Microstructure SG cast iron in a ferritic matrix
- 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

### WELDING PARAMETERS & ECONOMICAL DATA

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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.