

SK SMC-O

DIN 8555 : MF 7-GF-200-KP
ASME IIC SFA 5.21 : FeMn-Cr

DESCRIPTION

1

All purpose alloy, rebuilding and joining of Carbon and 14% Manganese steels, buffer layer prior to deposit hard overlay.

SUITABLE FOR

2

Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, repointing of shovel teeth, buffer layer for inter-particles crushers.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Fe
All Weld	0.37	16.0	0.4	12.80	Bal.

TYPICAL MECHANICAL PROPERTIES

4

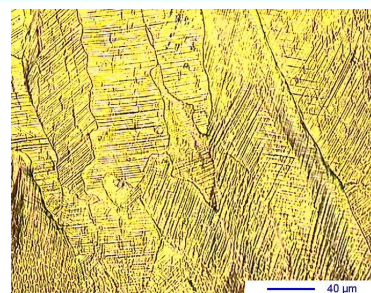
Hardness as welded

205 HB

GENERAL CHARACTERISTICS

5

- Microstructure Austenite
- Machinability Good with metallic carbides tipped tools
- Oxy-acetylene cutting Cannot be flame cut
- Deposit thickness As required
- Flux 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
1,2	120-150	26-30	35-40	52275	Spool 15 Kg	Standard
1,6	180-200	26-30	35-40	41299	Spool 15 Kg	On request
2,4	250-300	26-30	35-40	41317	Spool 15 Kg	On request
2,4	250-300	26-30	35-40	53832	Coil 25 Kg	On request with minimal quantity
2,8	300-350	26-30	35-40	41339	Coil 25 Kg	On request

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