

## SK SOUDOCORE 55 Ni-

DIN 8555 : MF 1-GF-200-GP  
ASME IIC SFA 5.20 : E 70 T4

### DESCRIPTION

1

Low-Hydrogen open arc wire for joining mild and low alloy steels in the flat position and horizontal fillets.

### SUITABLE FOR

2

Joining and build-up of carbon steels.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Ni	Fe	Al
All Weld	0.08	1.3	0.2	1.10	Bal.	1.4

### TYPICAL MECHANICAL PROPERTIES

4

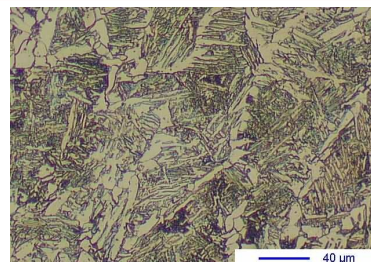
Hardness as welded

200 HB

### GENERAL CHARACTERISTICS

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- Microstructure Ferrite
- Machinability Excellent
- Oxy-acetylene cutting Cannot be flame cut
- Deposit thickness No restriction
- 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	150-200	26-30	35-40	29249	Spool 15 Kg	On request
1,6	180-200	26-30	35-40	29250	Spool 15 Kg	On request with minimal quantity
2,0	300-350	26-30	35-40	29251	Spool 7,50 Kg	On request with minimal quantity
2,4	325-400	26-30	35-40	29252	Spool 15 Kg	On request

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