

## SK TO 44

DIN 8555 : MF 10-GF-60-G

### DESCRIPTION

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Chromium-Niobium-Molybdenum alloy with addition of Tungsten and Vanadium designed to resist high stress grinding abrasion with low impact and solid erosion. The deposits will readily stress relief cracks.

### SUITABLE FOR

2

Wear plates, groundnut oil expeller screws, screen in the coal industry, bucket teeth on bucket-wheel excavators, shovel bucket teeth and lips.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Mo	Nb	W	V	Fe
All Weld	5.20	0.2	1.4	22.50	2.7	6.50	1.0	1	Bal.

### TYPICAL MECHANICAL PROPERTIES

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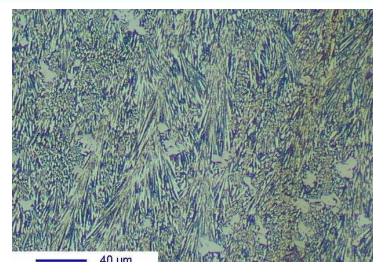
Hardness as welded

61 HRC

### GENERAL CHARACTERISTICS

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- Microstructure: Austenitic matrix with complex carbides of different types Chromium rich hexagonal primary carbides, eutectic carbides and nodular Niobium carbides.
- Machinability: Grinding only
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: 8 to 12 mm in 2 or 3 layers
- Metal cored



### WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
2,8	300-350	26-30	35-40	50922	Autopack 250 Kg	On request with minimal quantity

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.