SK 402-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 8-GF-150-KP

Characteristics

Austenitic alloy type 18Cr8Ni7Mn recommended for build up and buffer layer prior to hardfacing. It can also be used for joining of dissimilar metals.

Microstructure:	Austenite
Machinability:	Good with carbide tipped tools
Oxy-acetylene cutting:	Not possible
Deposit thickness:	As required
Shielding gas:	Argon 98% + Oxygen 2%

Field of use

Joining of wear plates on shovel buckets, railways and tramway lines, press rams, joining stainless steels to carbon manganese steels, building up and buttering before hardfacing, welding of 14%Mn steels, armour and hard to weld steels.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0,10	6,6	0,6	17,1	7,8	balance

Typical mechanical properties

Hardness as welded: 170 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	150-250	20-31	20 max.	15-18