SK 410C-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 5-GF-40-C

Characteristics

Alloy depositing a martensitic steel containing 13% Chromium giving a very good resistance to friction wear and corrosion.

Machinability:	Good with carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98% + Oxygen 2% or Argon 100%

Field of use

Continuous casting rollers, valve seats, impellers, steam turbine parts, tap-factory.

Typical analysis in %

C	Mn	Si	Cr	Fe
0,08	0,7	0,4	13,0	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18
2,4	250-350	20-31	20 max.	18-20

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.