SK 867WP-O

open arc metal cored wire

Classifications

DIN 8555

MF 10-GF-60-G

Characteristics

High Chromium alloy designed to resist high stress grinding abrasion with low impact. The deposit will show readily stress relief cracks. Welding properties optimized for wear plates manufacturing.

Microstructure:	Primary and eutectic carbides in an austenitic matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	8 to 10 mm in 2 to 3 layers

Field of use

Wear plates.

Typical analysis in %

C	Mn	Si	Cr	B	Fe
5.0	0.2	1.4	29.0	0.5	balance

Typical mechanical properties

Hardness as welded: 62 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 500	26 – 30	35 – 40

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.