SK A70-O/G

gas shielded metal cored wire

Classifications

DIN 8555

MF 10-GF-70-G

Characteristics

Special Chromium-Niobium-Boron alloy designed to give extreme resistance to high stress grinding abrasion without impact. The typical hardness is achieved in the first layer. The deposits will show stress relief cracks.

Microstructure:	Borides and Niobium carbides in eutectic matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	6 to 8 mm in 2 layers maximum
Shielding gas:	Argon 98% + Oxygen 2% (if not used as open-arc)

Field of use

Extrusion screws, screw conveyors, mixers, scrapers, subsoiler teeth, agriculture and earth moving machinery wear parts, etc.

Typical analysis in %

C	Mn	Si	Cr	Nb	B	Fe
2,6	1,7	0,6	14,8	4,7	2,2	balance

Typical mechanical properties

Hardness as welded: 68 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	200-300	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.