SK ABRA-MAX O/G

gas shielded metal cored wire

Classifications

DIN 8555

MF 6-GF-70-GT

Characteristics

Special hardfacing cored wire designed to give an extreme resistance against high stress grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks.

Microstructure:	Complex carbo-borides and borides homogeneously dispersed in the matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	ca. 8 mm in maximum 2 layers
Shielding gas:	Argon + 2% Oxygen (if not used as open arc)

Field of use

Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.

Typical analysis in %

C + Cr + Mo + Nb + W + V + B (Bal Fe)

Typical mechanical properties

Hardness as welded: 70 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1,2	130-180	22-26	15-25
1,6	180-230	26-30	20-35
2,0	200-250	26-30	20-40
2,4	250-300	26-30	20-40
2,8	300-350	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.