SK ZIP-O

open arc metal cored wire

Classifications

DIN 8555

MF 9-GF-150-C

Characteristics

Self shielded flux cored wire depositing a 19%Cr-17%Ni-5% Mo with a low Carbon. The structure of the deposited weld metal is entirely austenitic without ferrite.

Microstructure	Fully austenitic
Machinability	Good
Oxy-acetylene cutting	Not possible
Deposit thickness	Depends upon application and procedure used

Field of use

Corrosion resistant applications, repair of galvanisation tanks.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.03	1.5	0.8	19.5	16.7	4.6	BAL

Typical mechanical properties

Hardness as welded: 170 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1,6	180-220	26-30	35-40
2,4	250-300	26-30	35-40

All informations 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.