SK AP-O

open arc flux cored wire

Classifications	
DIN 8555	ASME IIC SFA 5.21
MF 7-GF-200-KP	FeMn-Cr

Characteristics

Multi-purpose cored wire, mainly used for rebuilding and joining of Carbon and 14% manganese steels. Can also be used as buffer layer prior to hard overlay. Work-hardenable alloy.

Microstructure: Austenite

Machinability: Good with metallic carbides tipped tools

Oxy-acetylene cuttin: Cannot be flame cut

Deposit thickness: As required

Field of use

Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, repointing of shovel teeth, buffer layer for inter-particles crushers.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.37	16.0	0.3	12.8	balance

Typical mechanical properties

Hardness as welded: 205 HB

After work hardening: 48 – 53 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	120 – 150	26 – 30	35 – 40
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 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.