

SK 250-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

ASME IIC SFA 5.21

MF 1-GF-225-GP

ERC Fe-1

Characteristics

Metal-cored wire designed for building-up by welding in horizontal and vertical-up positions under gas shielding.

Microstructure: Ferrite + Perlite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82 % + CO₂ 18 %

Field of use

Conveyor chains, sliding metal parts, gear teeth, shafts.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.09	1.2	0.5	0.4	balance

Typical mechanical properties

Hardness as welded: 225 HB

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V] [V]	Stick-out [mm]	Gas flow [L/min]
1.2	110 – 180	20 – 31	20 max.	10 – 18
1.6	150 – 250	20 – 31	20 max.	10 – 18