

SK 258 TIC-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-60-GP

Characteristics

Special Chromium-Titanium-Molybdenum martensitic alloy designed to resist high stress abrasion wear with heavy impact.

Microstructure: Finely dispersed Titanium carbides in a Martensitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Up to 6 layers

Shielding gas: Argon 98% + Oxygen 2%

Field of use

Bucket teeth and lips, inter-particles crusher roller, concrete pump parts, augers, crusher hammers, shredder hammers, crusher hammers, asphalt mixers blades, concrete pump parts.

Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
1.6	0.8	0.3	5.6	1.1	5.8	balance

Typical mechanical properties

Hardness as welded: 59 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.2	150 – 250	26 – 29	15 – 20	12 – 15
1.6	180 – 300	26 – 29	15 – 20	15 – 18