

<b>SK 258L-G</b>		low-alloyed steels				
<b>Classifications</b>		gas-shielded metal-cored wire				
DIN 8555						
MF 5-GF-45-GT						
<b>Characteristics</b>						
Martensitic alloy designed to give an outstanding resistance to low stress abrasion with heavy impact and high compressive stresses. The deposit is heat treatable and forgeable.						
Microstructure:	Martensite					
Machinability:	Good with Tungsten carbides or cubic Boron Nitride tipped tools					
Oxy-acetylene cutting:	Flame cut is difficult					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 98 % + Oxygen 2 %					
<b>Field of use</b>						
Steel mill rollers, blast furnace bells (seat area), dredger-buckets cylinders.						
<b>Typical analysis in %</b>						
C	Mn	Si	Cr	Mo	W	Fe
0.17	1.6	0.6	5.5	1.5	1.5	balance
<b>Typical mechanical properties</b>						
Hardness as welded: 45 HRC						
<b>Form of delivery and recommended welding parameters</b>						
<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Stick-out [mm]</i>	<i>Gas flow [L/min]</i>		
1.2	150 – 250	20 – 31	20 max.	12 – 15		
1.6	180 – 300	20 – 31	20 max.	15 – 18		
2.8	300 – 400	20 – 31	20 max.	20 – 22		