

SK 300-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 1-GF-300-GP

Characteristics

Build-up alloy designed for welding in horizontal and vertical-up positions under gas shielding.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82 % + CO₂ 18 %

Field of use

Conveyor chains, sliding metal parts, gear teeth, crane wheels, undercarriage links, shafts, buffer layer prior to hardfacing.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.25	1.5	0.4	1.4	balance

Typical mechanical properties

Hardness as welded: 300 HB

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.2	110 – 180	20 – 31	20 max.	12 – 15
1.6	150 – 250	20 – 31	20 max.	15 – 18