

SK 350-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 1-GF-350-GP

Characteristics

Rebuilding and hardfacing alloy for carbon steel parts.

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% or CO₂ 100%

Field of use

Sliding metal parts, gear teeth, undercarriage links, rollers and idlers, shafts, bushing.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.35	1.5	0.4	1.8	0.5	balance

Typical mechanical properties

Hardness as welded: 330 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
2.0	200 – 325	20 – 31	20 max.	15 – 18
2.4	250 – 350	20 – 31	20 max.	18 – 20