SK 450-G

low-alloyed steels

Classifications	gas-shielded metal-cored wire
DIN 8555	ASME IIC SFA 5.21
MF 1-GF-450-GP	ERC Fe-2

Characteristics

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

Microstructure: Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82 % + CO_2 18 % or CO_2 100 %

Field of use

Undercarriage rollers and idlers, crane wheels, sealing rings seats.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.27	1.1	0.2	2.3	0.5	balance

Typical mechanical properties

Hardness as welded: 47 HRC

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