

SK 500-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-50-GT

Characteristics

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

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82% + CO₂ 18% or CO₂ 100%

Field of use

Undercarriage rollers and idlers, shovel teeth, shear blades.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.26	1.3	0.7	5.0	0.5	balance

Typical mechanical properties

Hardness as welded: 52 HRC

Form of delivery and recommended welding parameters

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