

## SK 600-G

low-alloyed steels

### Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-60-GP

### Characteristics

Martensitic steel alloy designed for welding in horizontal and vertical-up positions under gas shielding. Its resistance to friction and low stress abrasive wear with moderate impact is excellent.

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82 % + CO<sub>2</sub> 18 % or CO<sub>2</sub> 100 %

### Field of use

Bucket teeth, gravel pumps, conveyor chains, sliding metal parts, gear teeth, crusher hammers, rock drills

### Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
0.52	1.5	1.2	5.9	0.8	0.05	balance

### Typical mechanical properties

Hardness as welded: 59 HRC

### Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
0.9	80 – 170	17 – 30	20 max.	12 – 15
1.2	110 – 180	20 – 31	20 max.	12 – 15
1.6	150 – 250	20 – 31	20 max.	15 – 18