

SK 600C-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-60-GP

Characteristics

Premium martensitic steel alloy designed for welding at low parameters in horizontal positions under gas shielding. Its resistance to friction and low stress abrasion wear with moderate impact is excellent.

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: 3.5 – 4.0 mm in one layer

Shielding gas: Argon 82 % + CO₂ 18 %

Field of use

Automatic surfacing of corners and edges of cutting tools.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.4	1.2	0.8	6.0	0.7	balance

Typical mechanical properties

Hardness as welded: 60 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.2	130 – 160	17 – 20	20 max.	12 – 15