

SK 650-G		low-alloyed steels					
Classifications		gas-shielded metal-cored wire					
DIN 8555							
MF 3-GF-60-GT							
Characteristics							
Martensitic steel alloy designed for welding in horizontal and vertical-up positions under gas shielding. Its resistance to friction and medium 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 ₂ 18 % or CO ₂ 100 %						
Field of use							
Dies, sliding metal parts, bucket teeth, gear teeth, crusher hammers, impact drills, etc.							
Typical analysis in %							
C	Mn	Si	Cr	Mo	W	V	Fe
0.45	0.9	0.6	5.5	1.4	1.6	0.5	balance
Typical mechanical properties							
Hardness as welded: 58 HRC							
Form of delivery and recommended welding parameters							
<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Stick-out [mm]</i>	<i>Gas flow [L/min]</i>			
1.2	110 – 180	20 – 31	20 max.	12 – 15			
1.6	150 – 250	20 – 31	20 max.	15 – 18			