

SK 797-G

manganese steels

Classifications

Gas-shielded flux-cored wire

DIN 8555

MF 7-GF-200-KP

Characteristics

Austenitic alloy without chromium designed for rebuilding 14 % manganese steel parts where parent-metal matching colour is a must.

Microstructure: Austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82 % + CO₂ 18 %

Field of use

Patching of Hadfield steel castings, crusher cylinders, crusher hammers, impactor bars.

Typical analysis in %

C	Mn	Si	Ni	Mo	Fe
0.9	14.5	0.3	2.0	0.5	balance

Typical mechanical properties

Hardness as welded: 185 HB

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