

SK A68-G

low-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 2-GF-65-G

Characteristics

Hardfacing alloy giving an excellent resistance to medium stress abrasive wear with moderate impact. A very high hardness is already achieved in the first layer.

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends on application and procedure used

Shielding gas: Argon 98% + Oxygen 2%

Field of use

Mixers and scrapers, excavator buckets, press screws parts.

Typical analysis in %

C	Mn	Si	Ni	B	Fe
0.5	1.3	1.0	1.6	3.7	balance

Typical mechanical properties

Hardness as welded: 62 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.2	110 – 250	20 – 31	20 max.	12 – 15
1.6	110 – 300	20 – 31	20 max.	15 – 20