

SK AP-G

manganese steels

Classifications gas-shielded metal-cored wire

DIN 8555

ASME IIC SFA 5.21

MF 7-GF-200-KP

FeMn-Cr

Characteristics

Multi-purpose cored wire, mainly used for rebuilding and joining of carbon and 14 % manganese steels. Can also be used as buffer layer prior to hard overlay. Work-hardenable alloy.

Microstructure: Austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Shielding gas: Argon 98 % + Oxygen 2 %

Field of use

Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, repointing of shovel teeth, buffer layer for inter-particles crushers.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.4	17.0	0.3	12.0	balance

Typical mechanical properties

Hardness as welded: 200 HB

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V] [V]	Stick-out [mm]	Gas flow [L/min]
1.6	150 – 250	20 – 31	20 max.	12 – 15

FCAW-G – gas-shielded cored wires

225