

**SK 255-G**

high-alloyed steels

**Classifications**

gas-shielded metal-cored wire

DIN 8555

ASME IIC SFA 5.21

UP 10-GF-60-G

FeCr-A9

**Characteristics**

Gas-shielded cored wire designed to deposit an alloy resistant to high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides and eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

Shielding gas: Argon 98 % + Oxygen 2 %

**Field of use**

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.

**Typical analysis in %**

C	Mn	Si	Cr	B	Fe
4.5	0.6	1.2	26.0	0.3	balance

**Typical mechanical properties**

Hardness as welded: 58 HRC

**Form of delivery and recommended welding parameters**

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.6	150 – 250	20 – 31	20 max.	15 – 18