

# SK 258 NbC-G

high-alloyed steels

## Classifications

gas-shielded metal-cored wire

DIN 8555

UP 6-GF-55-G

## Characteristics

Gas-shielded flux-cored wire designed to deposit a crack-free martensitic alloy.

Microstructure: Martensite, little residual austenite and dispersed NbC carbides

Precautions: Preheating temperature 250 °C  
Interpass temperature 300 °C

Stress-relieving: 500 °C for 6 to 8 hours

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98% + Oxygen 2%

## Field of use

Inter-particles crusher rollers.

## Typical analysis in %

C	Mn	Si	Cr	Nb	W	Fe
1.3	0.9	1.1	7.0	8.5	1.4	balance

## Typical mechanical properties

Hardness as welded: 54 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 – 300	20 – 31	20 max.	15 – 18