

SK HYDROCAV

high-alloyed steels

Classifications

gas-shielded metal-cored wire

DIN 8555

MF 6-GF-200-K

Characteristics

The SK Hydrocav is gas-shielded metal-cored wire suitable for surfacing of parts (especially soft martensitic 13 / 4 stainless steels) where high resistance to cavitation, corrosion, pressure and impact is required. Work-hardenable alloy.

Microstructure: Austenite type

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Shielding gas: Ar + 2% O₂

Field of use

Turbine blades, pumps.

Typical analysis in %

C	Mn	Si	Cr	Co	N	Fe
0.17	8.5	1.8	21.0	12.0	0.25	balance

Typical mechanical properties

Hardness as welded: 220 HB

Hardness after work hard: 40 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.	15 – 18