

**SK 219-S**

manganese steels

**Classifications**

SAW cored wire

DIN 8555

UP 7-GF-200 / 450-KP

**Characteristics**

Designed to deposit by submerged arc welding a fully austenitic alloy in a single layer on Carbon steel parts.

Microstructure: Austenite

Machinability: Good with carbides tipped tools

Oxy-acetylene cutting: Not possible

Deposit thickness: As required

Welding flux: Record SA

**Field of use**

Tramway and railway rails, crossovers, crossing frogs and curves.

**Typical analysis in %**

C	Mn	Si	Cr	Fe
0.95	18.0	1.0	4.6	balance

**Typical mechanical properties**

Hardness as welded: 205 HB

**Form of delivery and recommended welding parameters**

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
2.8	300 – 400	28 – 30	30 – 35	1.1	35 – 40
3.2	325 – 450	28 – 30	30 – 35	1.1	35 – 45