

SK 258 NbC-SA

Unalloyed and low-alloyed steels

Classifications

SAW cored wire

DIN 8555

UP 6-GF-60-G

Characteristics

Sub-arc 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: Up to 4 layers

Welding flux: Record SA

Field of use

Inter-particles crusher rollers.

Typical analysis in %

| C | Mn | Si | Cr | Nb | W | Fe |
|-----|-----|-----|-----|-----|-----|---------|
| 1.2 | 0.8 | 0.8 | 6.0 | 8.0 | 1.4 | balance |

Typical mechanical properties

Hardness as welded: 57 HRC

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] |
|-----------------------|-----------------|----------------|-------------------|-------------------------------|--------------------------|
| 3.2 | 325 – 500 | 28 – 32 | 30 – 35 | 1.1 | 40 – 50 |