

SK 263-SA

Unalloyed and low-alloyed steels

Classifications

SAW cored wire

DIN 8555

UP 6-GF-50-GP

Characteristics

Martensitic alloy giving a very good resistance against metal-to-metal and low stress abrasive wear at high temperature. The deposit is crack-free, heat treatable and forgeable.

Microstructure: Martensite

Machinability: Good with Tungsten carbides or cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA, Record SR

Field of use

Steel mill rollers, blast furnace bells (seat area), dredger-buckets cylinders.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.23	1.2	0.7	6.0	2.7	balance

Typical mechanical properties

Hardness as welded: 50 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