

SK 402-S

stainless steels

Classifications

SAW cored wire

DIN 8555

UP 8-GF-150 / 400-KPZ

Characteristics

Austenitic alloy type 18Cr8Ni7Mn recommended for build up and buffer layer prior to hardfacing. It can also be used for joining of dissimilar metals.

Microstructure: Austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Welding flux: Record SA

Field of use

Joining of wear plates on shovel buckets, rebuilding of rails, press rams, tramways rail bends.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0.07	6.6	1.0	17.0	8.0	balance

Typical mechanical properties

Hardness as welded: 150 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]
3.2	325 – 450	28 – 30	30 – 35	1.1	35 – 45