

SK 420-SA

stainless steels

Classifications

SAW cored wire

DIN 8555

UP 6-GF-55-C

Characteristics

Alloy depositing a martensitic steel containing 13 % Chromium giving a good resistance to metal-to-metal wear and corrosion.

Microstructure: Martensite

Machinability: Good with cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

Field of use

Dredging pump casings, continuous casting rollers.

Typical analysis in %

| C | Mn | Si | Cr | Fe |
|------|-----|-----|------|---------|
| 0.27 | 1.3 | 0.3 | 13.5 | balance |

Typical mechanical properties

Hardness as welded: 53 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] |
|-----------------------|-----------------|----------------|-------------------|----------------------------------|--------------------------|
| 2.4 | 275 – 450 | 28 – 30 | 30 – 35 | 1.1 | 35 – 45 |
| 3.2 | 325 – 500 | 28 – 32 | 30 – 35 | 1.1 | 40 – 50 |