

**Classifications**

SAW cored wire

DIN 8555

ASME IIC SFA 5.21

UP 7-GF-200-KP

FeMn-Cr

**Characteristics**

Multi-purpose cored wire, mainly used for rebuilding and joining of Carbon and 14 % Manganese steels. Can also be used as buffer layer prior to hard overlay. Work-hardenable alloy.

Microstructure: Austenite

Machinability: Good with metallic carbides tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Welding flux: Record SA, Record SR

**Field of use**

Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, re-pointing of shovel teeth, buffer layer for inter-particles crushers.

**Typical analysis in %**

C	Mn	Si	Cr	Fe
0.45	16.0	0.5	13.0	balance

**Typical mechanical properties**

Hardness as welded: 200 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]
2.4	275 – 450	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50