

Classifications

SAW cored wire

DIN 8555

UP 1-GF-300-P

Characteristics

Rebuilding alloy for Carbon steel parts. Can also be used as buffer layer prior to hard overlay.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

Field of use

Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.

Typical analysis in %

| C | Mn | Si | Cr | Mo | Fe |
|-----|-----|-----|-----|-----|---------|
| 0.1 | 0.9 | 0.6 | 0.5 | 0.3 | balance |

Typical mechanical properties

Hardness as welded: 280 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 | 280 – 350 | 26 – 30 | 30 – 35 | 1.1 | 35 – 45 |
| 3.2 | 325 – 450 | 28 – 30 | 30 – 35 | 1.1 | 35 – 45 |