

SK SOUDOCORE D-SA

Unalloyed and low-alloyed steels

Classifications

SAW cored wire

DIN 8555

ASME IIC SFA 5.17

UP 1-GF-200-GP

F7A8-EC1

Characteristics

Flux cored wire for submerged arc welding designed for rebuilding and buffering prior to hardfacing. High deposition rate. Excellent mechanical properties.

Microstructure: Ferrite

Machinability: Excellent

Oxy-acetylene cutting: Can be flame cut

Deposit thickness: No restriction

Welding flux: Record SA

Field of use

Cushion layer on inter-particles crusher cylinder (Polysius; Fuller).

Typical analysis in %

C	Mn	Si	Fe
0.09	1.5	0.5	balance

Typical mechanical properties

Hardness as welded: 190 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]
4.0	380 – 700	28 – 33	30	1.1	40 – 60