

Classifications

DIN 8555	ASME IIC SFA 5.23	ASME IIC SFA 5.23
UP 1-GF-200	F9P2-ECB1-B1	F10A0-ECB1-B1

Characteristics

Cored wire designed to deposit a 0,2 %C-0,5%Cr-0,2%Mo alloy for submerged arc welding of unalloyed and low alloyed steels.

Microstructure:	Ferritic
Machinability:	Good
Oxy-acetylene cutting:	Possible
Deposit thickness:	Depends upon application and procedure used
Welding flux:	Record SA

Field of use

Heat resistant steel, steel casting, buffer layers.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.13	1.0	0.4	0.6	0.3	balance

Typical mechanical properties

Hardness as welded: 250 HB

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 – 450	30 – 32	30 – 35	1.1	35 – 45