

Classifications

DIN 8555

UP 7-GF-200/450-KP

Characteristics

Designed to deposit by submerged arc welding a fully austenitic alloy in a single layer on Carbon steel parts.

Microstructure: Austenite

Machinability: Good with carbides tipped tools

Oxy-acetylene cutting: Not possible

Deposit thickness: As required

Welding flux: Record SA

Field of use

Tramway and railway rails, crossovers, crossing frogs and curves.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.95	18.0	1.0	4.6	balance

Typical mechanical properties

Hardness as welded: 205 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
2.8	300 – 400	28 – 30	30 – 35	1.1	35 – 40
3.2	325 – 450	28 – 30	30 – 35	1.1	35 – 45