

Characteristics and field of use

SK 235-M is a cored wire developed for arc spraying. This material produces a hard, abrasive and corrosion resistant coating up to service temperature of about 900 °C.

SK 235-M is used primarily as a hard corrosion resistant interface. We recommend to apply thickness not exceeding 12 mm.

Hardness as deposited: NA

Typical analysis in %

C	Mn	Si	Cr	B	Fe
0.06	1.8	1.7	29.0	3.4	balance

Welding instruction

Observe normal spraying practices, respiratory protection and proper air flow pattern advised.

For general spray practices, see AWS C2.1-73.

Thermal spraying is a completely safe process when performed in accordance with proper safety measures.

Become familiar with local safety regulations before starting spray operations.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Psi	Spray Dist [mm]
1.6	150 – 350	29 – 31	60 – 80	100 – 200