

Classifications

DIN 8555

UP 1-GF-40-P

Characteristics

Submerged arc surfacing wire for rebuilding and hard surfacing alloy of Carbon steel parts subjected to adhesive wear with impacts.

Microstructure: Bainite + Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

Field of use

Crawler tractor rollers and idlers, shafts, cylinders, mine car wheels, crane wheels.

Typical analysis in %

C	Mn	Si	Cr	Mo	V	Fe
0.14	1.6	0.7	2.0	0.7	0.4	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

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