

Classifications

DIN 8555	ASME IIC SFA 5.21
UP 10-GF-60-G	FeCr-A9

Characteristics

Cored Wire for sub-arc welding designed to resist high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides and eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

Welding flux: Record SA

Field of use

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.

Typical analysis in %

C	Mn	Si	Cr	Fe
4.6	0.9	0.5	27.0	balance

Typical mechanical properties

Hardness as welded: 58 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