

Classifications						
DIN 8555						
UP 6-GF-60-G						
Characteristics						
Sub-arc flux-cored wire designed to deposit a crack-free martensitic alloy.						
Microstructure:	Martensite, little residual austenite and dispersed NbC carbides					
Precautions:	Preheating temperature 250 °C / Interpass temperature 300 °C					
Stress-relieving:	500 °C for 6 to 8 hours					
Machinability:	Grinding only					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Up to 4 layers					
Welding flux:	Record SA					
Field of use						
Inter-particles crusher rollers.						
Typical analysis in %						
C	Mn	Si	Cr	Nb	W	Fe
1.2	0.8	0.8	6.0	8.0	1.4	balance
Typical mechanical properties						
Hardness as welded: 57 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 – 500	28 – 32	30 – 35	1.1	40 – 50	