

Classifications

DIN 8555

UP 6-GF-55-GT

Characteristics

Martensitic alloy designed to give an outstanding resistance to low stress abrasion with heavy impact and high compressive stresses. The deposit is heat treatable and forgeable.

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA, Record SR

Field of use

Cable sheaves, bed knives, steel mill rollers, crane wheels, forging dies.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	Fe
0.5	1.5	0.6	6.2	1.7	1.7	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]
2.4	275 – 450	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50
4.0	380 – 550	28 – 32	30 – 35	1.1	40 – 50