

## Classifications

DIN 8555

UP 6-GF-50-GP

## Characteristics

Martensitic alloy giving a very good resistance against metal-to-metal and low stress abrasive wear at high temperature. The deposit is crack-free, heat treatable and forgeable.

Microstructure: Martensite

Machinability: Good with Tungsten carbides or cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA, Record SR

## Field of use

Steel mill rollers, blast furnace bells (seat area), dredger-buckets cylinders.

## Typical analysis in %

| C    | Mn  | Si  | Cr  | Mo  | Fe      |
|------|-----|-----|-----|-----|---------|
| 0.23 | 1.2 | 0.7 | 6.0 | 2.7 | balance |

## Typical mechanical properties

Hardness as welded: 50 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               |