

## Classifications

DIN 8555

UP 6-GF-55-CG

## Characteristics

Martensitic alloy designed to resist metal-to-metal wear, corrosion and thermal fatigue.

Microstructure: Chromium carbides in a martensitic matrix with residual austenite

Machinability: Fair with carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Welding flux: Record SA

## Field of use

Pinch rollers, bending rollers, deflector rollers, looper rollers.

## Typical analysis in %

Mn	Si	Cr	Mo	Fe
1.3	0.4	16.0	0.5	balance

## Typical mechanical properties

Hardness as welded: 54 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