

Classifications

DIN 8555

UP 5-GF-40-C

Characteristics

Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1% Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure: Martensite + 10 % Ferrite

Machinability: Good with carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

Field of use

Continuous casting rollers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.05	1.0	0.3	12.5	5.0	0.9	balance

Typical mechanical properties

Hardness as welded: 39 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