

Characteristics and field of use

SK 420-M is a chrome steel cored wire made exclusively for arc spraying to ensure a good corrosion and oxidation resistance.

Hard coatings with good oxidation and corrosion resistances.

Hardness as deposited: NA

Typical analysis in %

C	Mn	Si	Cr	Fe
0.4	0.5	0.4	14.0	balance

Welding instruction

Observe normal spraying practices, respiratory protection and proper air flow pattern advised.

For general spray practices, see AWS C2.1-73.

Thermal spraying is a completely safe process when performed in accordance with proper safety measures.

Become familiar with local safety regulations before starting spray operations.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Psi	Spray Dist [mm]
1.6	150 – 350	29 – 31	60 – 80	100 – 125