

## Classifications

DIN 8555

UP 6-GF-55-C

## Characteristics

Alloy depositing a martensitic steel containing 13 % Chromium giving a good resistance to metal-to-metal wear and corrosion.

Microstructure: Martensite

Machinability: Good with cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

## Field of use

Dredging pump casings, continuous casting rollers.

## Typical analysis in %

C	Mn	Si	Cr	Fe
0.27	1.3	0.3	13.5	balance

## Typical mechanical properties

Hardness as welded: 53 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