

## Classifications

DIN 8555

UP 5-GF-200-C

## Characteristics

Alloy depositing a ferritic steel containing 17 % Chromium designed to resist corrosion at high temperatures, particularly in presence of sulphurous gas.

Microstructure: Ferrite and few martensite

Machinability: Verry good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA, Record SK

## Field of use

Continuous casting rollers situated at the top of the line, valves, steam and gas turbine parts, valve seats.

## Typical analysis in %

C	Mn	Si	Cr	Fe
0.04	0.9	0.5	19.5	balance

## Typical mechanical properties

Hardness as welded: 175 HB

## 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	250 – 350	28 – 30	30 – 35	1.1	35 – 45
2.8	300 – 400	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50