

## Classifications

DIN 8555

UP 5-GF-45

## Characteristics

Alloy depositing a ferritic-martensitic steel in two layers on a CrMo steel containing 0,4 % C. It has been designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure: Martensite + 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	Nb	V	Fe
0.05	1.0	0.7	16.5	3.7	1.7	0.2	0.2	balance

## Typical mechanical properties

Hardness as welded: 33 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 – 450	28 – 30	25 – 35	1.1	30 – 50