

Classifications

DIN 8555

UP 1-GF-300-P

Characteristics

Rebuilding alloy for Carbon steel parts. Can also be used as buffer layer prior to hard overlay.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

Field of use

Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.1	0.9	0.6	0.5	0.3	balance

Typical mechanical properties

Hardness as welded: 280 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	280 – 350	26 – 30	30 – 35	1.1	35 – 45
3.2	325 – 450	28 – 30	30 – 35	1.1	35 – 45