

## Classifications

DIN 8555	ASME IIC SFA 5.23	ASME IIC SFA 5.23
UP 1-GF-250	F9P2-ECB2-B2	F10A10-ECB2-B2

## Characteristics

Cored wire for joining and rebuilding of mild and low alloy steels. Can also be used as buffer layer prior to hardfacing.

Microstructure: Ferritic

Machinability: Good with conventional tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux: Record SA

## Field of use

Joining and rebuilding of heat resistant steel and steel casting parts. Buffer layers.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.02	0.8	0.6	1.1	0.4	balance

## Typical mechanical properties

Hardness as welded: 230 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
2.0	250 – 400	28 – 30	30 – 35	1.1	35 – 45
2.4	275 – 450	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 30	30 – 35	1.1	35 – 45