

Classifications					
DIN 8555		ASME IIC SFA 5.17			
UP 1-GF-200-GP		F7A8-EC1			
Characteristics					
Flux cored wire for submerged arc welding designed for rebuilding and buffering prior to hardfacing. High deposition rate. Excellent mechanical properties.					
Microstructure:	Ferrite				
Machinability:	Excellent				
Oxy-acetylene cutting:	Can be flame cut				
Deposit thickness:	No restriction				
Welding flux:	Record SA				
Field of use					
Cushion layer on inter-particles crusher cylinder (Polysius; Fuller).					
Typical analysis in %					
C	Mn	Si	Fe		
0.09	1.5	0.5	balance		
Typical mechanical properties					
Hardness as welded: 190 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
4.0	380 – 700	28 – 33	30	1.1	40 – 60