# SK A45-0

Open arc metal cored wire

## Classifications

| EN 14700 | DIN 8555 |
|---|---|
| T Fe16 | MF 10-GF-65-GT |

## Characteristics and typical fields of application

Chromium-Niobium-Molybdenum alloy with addition of Tungsten and Vanadium designed to resist high stress grinding abrasion with low impact and solid erosion at service temperatures up to 650 °C. The deposits will readily show stress relief cracks.

Microstructure: Austenitic matrix with hexagonal primary and eutectic carbides and nodular Nb carbides with complex combined carbides

Oxy-acetylene cutting: Cannot be flame cut

Machinability: Grinding only

Deposit thickness: 8 to 12 mm in 2 or 3 layers

Field of use: Wear plates, sinter finger crushers, exhaust fan blades in pellet plants, perlite crushers, bucket teeth and lips on bucket-wheel excavators, boiler fan blades, burden area in blast furnace bells, etc.

## Typical analysis

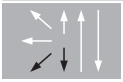
| | C | Si | Mn | Cr | Mo | W | V | Nb | Fe |
|---|---|---|---|---|---|---|---|---|---|
| wt.-% | 5.3 | 0.7 | 0.2 | 22 | 6.4 | 1.9 | 0.8 | 6 | bal. |

## Mechanical properties of all-weld metal - typical values (min. values)

| Condition | Hardness |
|---|---|
| | |
| u | 64 |

u - untreated, as welded

## Operating data



| | |
|---|---|
| **Polarity** | DC + |
| **Shielding gas (EN ISO 14175)** | NO GAS |
| **Stick-Out** | 35-40 mm |

| Dimension mm | Current A | Voltage V |
|---|---|---|
| 1.6 | 180-200 | 26-30 |
| 2.0 | 200-250 | 26-30 |
| 2.4 | 250-300 | 26-30 |
| 2.8 | 300-350 | 26-30 |

## Approvals

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