Open arc cored wires for repair, anti-wear and anti-corrosion

Manganese steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
SK N AP-O DIN 8555: MF 7-GF-200-KP	Hardness as welded: 205 HB	2.8	-	Multipurpose cored wire mainly used for rebuilding and joining of Carbon and 14% Manganese steels. It can also be used as buffer layer prior to hard overlay. Work-hardenable alloy. Field of use: Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantels, repointing of shovel teeth, buffer layer for inter-particles crushers.

Low alloy steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
SK BU - O DIN 8555: MF 1-GF-300-P	Hardness as welded: 280 HB	1.2 1.6 2.0 2.4 2.8	-	Rebuilding alloy for Carbon steel parts. It can also be used as buffer layer prior to hard overlay. Field of use: Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.
SK 260 NbC-O DIN 8555: MF 6-GF-60	Hardness as welded: 60 HRC	1.6 2.8 3.2	-	Special crack-free martensitic alloy enhanced with Boron designed to resist high stress abrasive wear. Field of use: Hardbanding of drilling pipes.

High alloyed steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
UTP AF VANADIUM 500	-	2.8	-	UTP AF 500 Vanadium tubular wire based on chromium carbonates and vanadium was specially developed for applications “Chapisco” (spraying) on the shirts of sugar cane milling industry. Its application through automated or semi-automatic process is quite versatile, allowing it to be applied both outside and during the milling because it has an aggressive type spray arc ensuring optimal spraying in the mill’s frizes. Due to the high energy used for its application, the weld droplets melt on the frieze on a larger area than what normally occurs with the coated electrode, thus ensuring greater “Chapisco” durability and keeping the shirt always in good condition to receive the next application, providing the maximum bagasse use.

High alloyed steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
SK N 162 - O DIN 8555: MF 10-GF-65-G	Hardness as welded: 63 HRC	2.4 2.8	-	High Chromium alloy designed to resist high stress grinding abrasion with low impact. The deposit will show readily stress relief cracks. Field of use: Gyratory crushers cones and mantles, vertical roller mills, coal pulverizer rolls, wear plates, etc.
SK 258 TIC-O DIN 8555: MF 6-GF-60-GP	Hardness as welded: 58 HRC	1.2 1.6 2.0 2.4 2.8	-	Martensitic Chromium-Titanium alloy designed to resist high stress abrasion with heavy impact. Deposits usually do not relieve cracks. Field of use: Crusher rollers, crusher hammers, asphalt mixer blades, agricultural tools, shovel bucket teeth and lips, bulldozer blades, cane knives and shredders, bed knives in the wood pulp industry.
SK A43-O DIN 8555: MF 10-GF-65-G	Hardness as welded: 64 HRC	1.6 2.0 2.4 2.8	-	CrNb alloy designed to resist high stress grinding abrasion at service temperature not exceeding 450°C. The deposit will readily show stress relief cracks. Field of use: Shovel, excavator, dredge and dragline bucket lips and teeth, hammers, rippers, crushing equipment, wear plates, expeller screws, giratory crushers, etc.
SK A45-O DIN 8555: MF 10-GF-65-GT	Hardness as welded: 63 HRC	1.6 2.0 2.4 2.8	-	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. 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.
SK N A45-O DIN 8555: MF 10-GF-65-GT	Hardness as welded: 63 HRC	2.8	-	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. 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.
SK ABRA - MAX O/G DIN 8555: MF 6-GF-70-GT	Hardness as welded: 70 HRC	1.6 2.0 2.4 2.8	-	Special hardfacing cored wire designed to give an extreme resistance against high stress grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks. Shielding gas: Argon + 2% Oxygen (if not used as open arc). Field of use: Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.