

## Classifications

EN 14700

DIN 8555

T Z Fe7

UP 5-GF-350-C

## Characteristics

Alloy depositing a low carbon ferritic-martensitic steel containing 14% Chromium, 6% Nickel and 2% Molybdenum. This composition has been especially developed to metal-to-metal wear and resist thermal fatigue fire cracking in high corrosive conditions

Microstructure: Martensite + Ferrite + residual austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: depends on the application and procedure used

Welding flux: Record SK

Polarity: DC- recommended

## Field of use

Continuous casting rollers.

## Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.02	0.6	0.5	14.5	6.2	2.7	balance

## Typical mechanical properties

Hardness as welded: 36 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
1.6	200 – 300	27 – 30	max. 25	1.1	35 – 45
2.4	300 – 400	29 – 31	max. 30	1.1	35 – 45