

DESCRIPTION

- Special agglomerated flux for hardfacing with high Nitrogen containing flux cored wire as SK 742N-SK.
- Very good slag removal and weld bead appearance make this flux particularly suitable for the hardfacing of continuous casting rolls.

GENERAL CHARACTERISTICS

- Current DC+ - 1000 A max.
- Basicity index 3.3 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.8
- Consumption 0.7 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C

TYPICAL WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	V	N
SK 742N-SK	0.07	1.5	0.3	13.0	3.2	1.3	0.1	0.1	0.05

3 Layers on 0.2% C - steel.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Hardness	Structure
SK 742N-SK	44 HRc	Martensite+Ferrite

PACKING

25 kg (bag) : SAP Stock number : 29190.