SK ANTINIT DUR 500

gas shielded metal cored wire

Classifications

DIN 8555

MF 9-GF-45-CT

Characteristics

For Hardfacing of or austenitic steels exposed to general corrosion, frictional wear, cavitation , or to high surface pressure. For use at temperatures up to 550°C. Offers additionally enhanced resistance to pitting and intergranular corrosion. Preheating to 450-500°C.

Microstructure:	Austenite + Ferrite + some chromium carbides at the grain boundaries
Machinability:	Difficult
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	As required if interpass temperature (min 400°C) is correctly applied
Shielding gas:	Argon 98 % + Oxygen 2% or Argon 100%

Field of use

Hardsurfacing of the sealing faces of valves and fittings, casings, chutes, slideways, mixer parts, mixer blades and other parts where a low friction coefficient is called for.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Nb
0,07	4,3	4,5	17,5	8,0	5,4	1,0

Typical mechanical properties

Hardness as welded: 43 HRC	After PWHT (2-6h) at 550°C: 53 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	200-300	20-21	20 max.	15-18
2,4	250-350	20-31	20 max.	15-18