WEARcore Dur 200-O (SK SOUDOCORE S8-O)
open arc flux cored wire

Classifications
EN 14700
T Z Fe1

Characteristics
Open-arc flux cored wire designed for joining and rebuilding of mild and low alloy steels. High deposition rate for applications in flat positions. Highly crack resistant and easy slag removal properties.

- Microstructure: Ferrite
- Machinability: Good
- Oxy-acetylene cutting: Possible
- Deposit thickness: No restriction
- Shielding gas: Not applicable

Field of use
Joining and build-up of carbon steels. Maintenance of slag ladles in steelmaking processes.

Typical analysis in %

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Al</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.28</td>
<td>0.4</td>
<td>0.1</td>
<td>1.50</td>
<td>balance</td>
</tr>
</tbody>
</table>

Typical mechanical properties
Hardness as welded: 190 HB

Recommended welding parameters

<table>
<thead>
<tr>
<th>Wire diameter [mm]</th>
<th>Amperage [A]</th>
<th>Voltage [V]</th>
<th>Stick-Out [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.0</td>
<td>200 – 550</td>
<td>26 – 35</td>
<td>25 – 50</td>
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</table>

All information provided is based upon careful investigation and intensive research. However, we do not assume any liability for correctness and information is subject to change without notice.

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www.voestalpine.com/welding