

Classifications				
DIN 8555				
MF 10-GF-65-G				
Characteristics				
High Chromium alloy designed to resist high stress grinding abrasion with low impact. The deposit will show readily stress relief cracks.				
Microstructure:	Primary carbides and M ₇ C ₃ eutectic carbides in an austenitic matrix			
Machinability:	Grinding only			
Oxy-acetylene cutting:	Cannot be flame cut			
Deposit thickness:	10 to 15 mm maximum in 3 layers			
Field of use				
Gyratory crushers cones and mantles, vertical roller mills, coal pulverizer rolls, wear plates, etc.				
Typical analysis in %				
C	Mn	Si	Cr	Fe
5.4	0.2	1.3	27.0	balance
Typical mechanical properties				
Hardness as welded: 63 HRC				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	
2.4	250 – 300	26 – 30	35 – 40	
2.8	300 – 500	26 – 30	35 – 40	