

Classifications

DIN 8555

MF 1-GF-150-P

Characteristics

Rebuilding alloy for Carbon steel parts.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: No restriction

Field of use

Gears, axles, wheels...

Typical analysis in %

C	Mn	Si	Ti	Fe
0.04	0.7	0.4	2.8	balance

Typical mechanical properties

Hardness as welded: 170 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.8	300 – 350	26 – 30	35 – 40