

Classifications				
DIN 8555				
MF 10-GF-55-G				
Characteristics				
Open-arc wire depositing a medium Chromium carbide alloy designed to resist grinding abrasive wear with medium impact.				
Microstructure:	Interdendritic eutectic carbides in an austenitic matrix			
Machinability:	Grinding only			
Oxy-acetylene cutting:	Cannot be flame cut			
Deposit thickness:	10 to 12 mm in 2 to 3 layers			
Field of use				
Final overlay on gyratory crusher mantles, augers, crusher hammers and crusher rollers, palm kernels expeller screws.				
Typical analysis in %				
C	Mn	Si	Cr	Fe
3.5	1.3	1.7	16.5	balance
Typical mechanical properties				
Hardness as welded: 56 HRC				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	
1.2	120 – 150	26 – 30	35 – 40	
1.6	180 – 200	26 – 30	35 – 40	