

Classifications

DIN 8555

MF 1-GF-45-G

Characteristics

Open-arc wire designed to deposit an alloy resistant to adhesive wear with impacts.

Microstructure: Martensite

Machinability: Good with metallic carbides or Boron Nitride tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Field of use

Crawler tractor rollers and idlers, crane wheels, shovel bucket rollers, shafts.

Typical analysis in %

C	Mn	Si	Cr	Fe
0.17	1.4	0.7	2.8	balance

Typical mechanical properties

Hardness as welded: 44 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40