

Classifications

DIN 8555	ASME IIC SFA 5.21
MF 10-GF-60-G	FeCr-A9

Characteristics

Open-arc metal cored wire designed to deposit a metal resistant to high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides and eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

Field of use

Concrete pumps, mixer parts, conveyer screws, etc.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
5.0	0.2	0.5	28.0	1.3	balance

Typical mechanical properties

Hardness as welded: 60 HRC

Recommended welding parameters

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