

Classifications

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

Characteristics

Gas shielded cored wire designed to deposit an alloy 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

Shielding gas: Argon 98% + Oxygen 2%

Field of use

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.

Typical analysis in %

C	Mn	Si	Cr	B	Fe
4,5	0,6	1,2	26,0	0,3	balance

Typical mechanical properties

Hardness as welded: 58 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	150-250	20-31	20 max.	15-18