

Classifications				
DIN 8555				
MF 10-GF-65-G				
Characteristics				
Open-arc cored wire depositing an alloy designed to resist high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.				
Microstructure:	Primary Chromium carbides (70 %) in an eutectic matrix			
Machinability:	Grinding only			
Oxy-acetylene cutting:	Cannot be flame cut			
Deposit thickness:	10 to 12 mm maximum in 2 to 3 layers			
Field of use				
Wear plates, mining and earthmoving equipment, sand dredge parts, drag line components, etc.				
Typical analysis in %				
C	Mn	Si	Cr	Fe
6.2	2.5	1.4	25.0	balance
Typical mechanical properties				
Hardness as welded: 63 HRC				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	
2.8	300 – 550	26 – 34	35 – 40	