

## Classifications

DIN 8555

MF 10-GF-65-G

## Characteristics

High Chromium carbide alloy designed to resist high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary Chromium carbides (70 %) and eutectic carbides in an austenitic 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

Coal pulverizing rollers, mining and earthmoving equipment, sand dredge parts, drag line components, etc.

## Typical analysis in %

C	Mn	Si	Cr	Fe
5.5	1.1	1.2	25.7	balance

## Typical mechanical properties

Hardness as welded: 63 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40