

| Classifications | | | | | | |
|--|--|-------------|----------------|------------------|-----|---------|
| DIN 8555 | | | | | | |
| MF 6-GF-55-G | | | | | | |
| Characteristics | | | | | | |
| Gas shielded flux-cored wire designed to deposit a crack-free martensitic alloy. | | | | | | |
| Microstructure: | Martensite, little residual austenite and dispersed NbC carbides | | | | | |
| Precautions: | Preheating temperature 250°C Interpass temperature 300°C | | | | | |
| Stress-relieving: | 500°C for 6 to 8 hours | | | | | |
| Machinability: | Grinding only | | | | | |
| Oxy-acetylene cutting: | Cannot be flame cut | | | | | |
| Deposit thickness: | Depends upon application and procedure used | | | | | |
| Shielding gas: | Argon 98% + Oxygen 2% | | | | | |
| Field of use | | | | | | |
| Inter-particles crusher rollers. | | | | | | |
| Typical analysis in % | | | | | | |
| C | Mn | Si | Cr | Nb | W | Fe |
| 1,3 | 0,9 | 1,1 | 7,0 | 8,5 | 1,4 | balance |
| Typical mechanical properties | | | | | | |
| Hardness as welded: 54 HRC | | | | | | |
| Recommended welding parameters | | | | | | |
| Wire diameter [mm] | Amperage [A] | Voltage [V] | Stick-Out [mm] | Gas-Rate [L/min] | | |
| 1,6 | 150-300 | 20-31 | 20 max. | 15-18 | | |