

Classifications

DIN 8555

MF 6-GF-60-G

Characteristics

Open-arc 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: Up to 4 layers

Field of use

Inter-particles crusher rollers.

Typical analysis in %

C	Mn	Si	Cr	Nb	W	Fe
1.4	0.7	1.2	5.3	8.5	1.5	balance

Typical mechanical properties

Hardness as welded: 57 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.8	300 – 350	26 – 30	35 – 40
3.2	350 – 400	26 – 30	35 – 40