

## Classifications

DIN 8555

MF 6-GF-60-GP

## Characteristics

Special Chromium-Titanium-Molybdenum martensitic alloy designed to resist high stress abrasion wear with heavy impact.

Microstructure: Finely dispersed Titanium carbides in a Martensitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Up to 6 layers

Shielding gas: Argon 98% + Oxygen 2%

## Field of use

Bucket teeth and lips, inter-particles crusher roller, concrete pump parts, augers, crusher hammers, shredder hammers, crusher hammers, asphalt mixers blades, concrete pump parts.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
1,6	0,8	0,3	5,6	1,1	5,8	balance

## Typical mechanical properties

Hardness as welded: 59 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	150-250	26-29	15-20	12-15
1,6	180-300	26-29	15-20	15-18