

<b>Classifications</b>						
DIN 8555						
MF 6-GF-55-GT						
<b>Characteristics</b>						
Martensitic alloy designed to give an outstanding resistance to low stress abrasion with heavy impact and high compressive stresses. The deposit is heat treatable and forgeable.						
Microstructure:	Martensite					
Machinability:	Grinding only					
Oxy-acetylene cutting:	Flame cut is difficult					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 98% + Oxygen 2%					
<b>Field of use</b>						
Cable sheaves, bed knives, steel mill rollers, crane wheels, forging dies.						
<b>Typical analysis in %</b>						
C	Mn	Si	Cr	Mo	W	Fe
0,45	1,6	0,8	5,5	1,3	1,3	balance
<b>Typical mechanical properties</b>						
Hardness as welded: 53 HRC						
<b>Recommended welding parameters</b>						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]		
1,2	110-180	20-31	20 max.	12-15		
1,6	150-300	20-31	20 max.	15-18		
2,8	300-400	20-31	20 max.	20-22		