

Classifications

DIN 8555

MF 6-GF-55-GT

Characteristics

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

Field of use

Cable sheaves, bed knives, steel mill rollers, crane wheels, forging dies.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	Fe
0.47	1.5	0.8	5.7	1.4	1.5	balance

Typical mechanical properties

Hardness as welded: 55 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	125 – 180	26 – 30	35 – 40
1.6	200 – 300	26 – 30	35 – 40
2.0	200 – 300	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40