

## Classifications

DIN 8555

MF 5-GF-45-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: Good with Tungsten carbides or cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98% + Oxygen 2%

## Field of use

Steel mill rollers, blast furnace bells (seat area), dredger-buckets cylinders.

## Typical analysis in %

C	Mn	Si	Cr	Mo	W	Fe
0,17	1,6	0,6	5,5	1,5	1,5	balance

## Typical mechanical properties

Hardness as welded: 45 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	150-250	20-31	20 max.	12-15
1,6	180-300	20-31	20 max.	15-18
2,8	300-400	20-31	20 max.	20-22