

Classifications						
DIN 8555						
MF 6-GF-45-GT						
Characteristics						
Martensitic alloy giving a very good resistance to metal-to-metal and low stress abrasive wear at high temperature. The deposit is crack-free, 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					
Field of use						
Steel mill rollers, blast furnace bells (seat area), dredger-buckets cylinders.						
Typical analysis in %						
C	Mn	Si	Cr	Mo	W	Fe
0.25	1.4	0.7	5.3	1.3	1.2	balance
Typical mechanical properties						
Hardness as welded: 46 HRC						
Recommended welding parameters						
Wire diameter [mm]	Amperage [A]		Voltage [V]		Stick-Out [mm]	
2.4	250 – 300		26 – 30		35 – 40	
2.8	300 – 350		26 – 30		35 – 40	