

Classifications

DIN 8555

MF 6-GF-60

Characteristics

Special crack-free martensitic alloy enhanced with Boron designed to resist high stress abrasive wear.

Microstructure: Martensite and primary niobium carbides

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Up to 4 layers

Field of use

Hardbanding of drilling pipes.

Typical analysis in %

| C | Mn | Si | Cr | Nb | W | B | Fe |
|-----|-----|-----|-----|-----|-----|-----|---------|
| 1.2 | 0.6 | 1.4 | 5.3 | 8.3 | 1.2 | 2.0 | balance |

Typical mechanical properties

Hardness as welded: 60 HRC

Recommended welding parameters

| Wire diameter [mm] | Amperage [A] | Voltage [V] | Stick-Out [mm] |
|--------------------|--------------|-------------|----------------|
| 1.6 | 180 – 200 | 26 – 30 | 35 – 40 |
| 2.8 | 300 – 350 | 26 – 30 | 35 – 40 |
| 3.2 | 350 – 400 | 26 – 30 | 35 – 40 |