

Classifications							
DIN 8555							
MF 10-GF-65-GZ							
Characteristics							
Hardfacing cored wire for open arc welding designed to surface parts subject to high stress grinding abrasion without impact up to high temperatures (up to 650 °C).							
Microstructure:	Austenitic matrix with complex carbides						
Machinability:	Grinding only						
Oxy-acetylene cutting:	Cannot be flame cut						
Deposit thickness:	8 to 10 mm in 2 to 3 layers						
Field of use							
Grizzly bars, chutes, conveyor screws, mixers, mining and earth moving equipment wear parts, clinker crushers, etc.							
Typical analysis in %							
C	Mn	Si	Cr	Nb	V	B	Fe
4.9	0.2	1.0	11.3	6.8	5.7	0.55	balance
Typical mechanical properties							
Hardness as welded: 64 HRC							
Recommended welding parameters							
Wire diameter [mm]	Amperage [A]		Voltage [V]		Stick-Out [mm]		
1.2	180 – 200		26 – 30		35 – 40		
2.4	250 – 300		26 – 30		35 – 40		
2.8	300 – 350		26 – 30		35 – 40		