

Classifications					
DIN 8555					
MF 1-GF-300-P					
Characteristics					
Self shielded flux-cored wire to be used for rebuilding of Carbon steel parts.					
Microstructure:	Bainite				
Machinability:	Good				
Oxy-acetylene cutting:	Possible				
Deposit thickness:	Depends upon application and procedure used				
Field of use					
Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.					
Typical analysis in %					
C	Mn	Si	Cr	Mo	Fe
0.1	1.1	0.7	0.5	0.3	balance
Typical mechanical properties					
Hardness as welded: 285 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]	
1.6	180 – 200	26 – 30		35 – 40	