

Classifications					
DIN 8555					
MF 9-GF-150					
Characteristics					
Open-arc wire with slag depositing a 23 % Chromium 12 % Nickel low carbon composition suitable for joining dissimilar metals and as buffer layer prior to hard overlays.					
Microstructure:	Austenite + ferrite				
Machinability:	Good				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	No restriction				
Field of use					
Stainless steel cladding on carbon steels, buffer layers on difficult to weld steels, Corrosion resistant overlays on rail heads submitted to corrosive action.					
Typical analysis in %					
C	Mn	Si	Cr	Ni	Fe
0.03	0.8	0.9	23.0	12.0	balance
Typical mechanical properties					
Hardness as welded: 170 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]		Voltage [V]		Stick-Out [mm]
1.6	180 – 220		26 – 30		35 – 40