

Classifications

DIN 8555

MF 7-GF-200-KP

Characteristics

Self shielded flux cored wire depositing an austenitic alloy designed for rebuilding of 14 % Manganese steel parts.

Microstructure: Austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut.

Deposit thickness: As required

Field of use

Crusher cylinders, crusher hammers, impactor bars.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
1.12	14.1	0.2	3.3	3.5	balance

Typical mechanical properties

Hardness as welded: 200 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.4	250 – 300	26 – 30	35 – 40