

Classifications					
DIN 8555					
MF 1-GF-350-GP					
Characteristics					
Rebuilding and hardfacing alloy for carbon steel parts.					
Microstructure:	Bainite				
Machinability:	Good				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	Depends upon application and procedure used				
Shielding gas:	Argon 82% + CO ₂ 18% or CO ₂ 100%				
Field of use					
Sliding metal parts, gear teeth, undercarriage links, rollers and idlers, shafts, bushing.					
Typical analysis in %					
C	Mn	Si	Cr	Mo	Fe
0,35	1,5	0,4	1,8	0,5	balance
Typical mechanical properties					
Hardness as welded: 330 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]	
1,2	110-180	20-31	20 max.	12-15	
1,6	150-250	20-31	20 max.	15-18	
2,0	200-325	20-31	20 max.	15-18	
2,4	250-350	20-31	20 max.	18-20	