

Classifications

DIN 8555

MF 4-GF-50-ST

Characteristics

Special iron base alloy designed to rebuild parts in the rubber industry.

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2%

Field of use

Rubber mixers and blenders.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	W	V	Fe
0,7	1,2	0,9	12,0	0,7	3,8	0,9	2,0	balance

Typical mechanical properties

Hardness as welded: 47 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
2,0	250-350	20-31	20 max.	15-18