

Classifications						
DIN 8555						
MF 5-GF-400-C						
Characteristics						
Self shielded cored wire depositing a ferritic-martensitic steel designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.						
Microstructure:	Martensite + 10 % Ferrite					
Machinability:	Good					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Up to 4 layers					
Field of use						
Hardfacing of continuous casting rollers.						
Typical analysis in %						
C	Mn	Si	Cr	Ni	Mo	Fe
0.03	0.5	0.6	15.5	5.2	0.5	balance
Typical mechanical properties						
Hardness as welded: 42 HRC						
Recommended welding parameters						
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]		
1.6	180 – 220	26 – 30		30 – 35		
2.0	200 – 300	26 – 30		30 – 35		
2.4	250 – 360	26 – 30		30 – 35		