

## Classifications

DIN 8555

MF 1-GF-40-P

## Characteristics

Open-arc wire designed for rebuilding and hardfacing of Carbon steel parts subjected to adhesive wear with impacts.

Microstructure: Bainite + Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

## Field of use

Crawler tractor rollers and idlers, shafts, cylinders, mine car wheels, crane wheels.

## Typical analysis in %

C	Mn	Si	Cr	Fe
0.13	0.7	0.6	2.4	balance

## Typical mechanical properties

Hardness as welded: 40 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40