

Classifications

DIN 8555	EN 14700
MF-6-GF-300-C	T Z Fe7

Characteristics

Alloy depositing a ferritic steel containing 17% Chromium enhanced with Molybdenum addition designed to resist corrosion at high temperatures, particularly in presence of sulphurous gas.

Microstructure:	Ferrite and few martensite
Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	If required Argon 98% + Oxygen 2%

Field of use

Continuous casting rollers, valves, steam and gas turbine parts, valve seats.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.25	1.0	0.6	19.0	0.9	balance

Typical mechanical properties

Hardness as welded: 260 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1.6	150-250	20-31	20 max.	15-18