

## Classifications

DIN 8555

MF 5-GF-200-C

## Characteristics

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

Microstructure: Ferrite and few martensite

Machinability: Verry good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98% + Oxygen 2%

## Field of use

Continuous casting rollers situated at the top of the line, valves, steam and gas turbine parts, valve seats.

## Typical analysis in %

C	Mn	Si	Cr	Ti	Fe
0,06	0,8	0,6	17,8	0,2	balance

## Typical mechanical properties

Hardness as welded: 190 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