

## Classifications

DIN 8555

MF 5-GF-250-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: Very good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

## 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   | Fe      |
|------|-----|-----|------|---------|
| 0.04 | 0.9 | 0.2 | 17.0 | balance |

## Typical mechanical properties

Hardness as welded: 260 HB

## Recommended welding parameters

| Wire diameter [mm] | Amperage [A] | Voltage [V] | Stick-Out [mm] |
|--------------------|--------------|-------------|----------------|
| 1.6                | 180 – 200    | 26 – 29     | 35 – 40        |
| 2.0                | 200 – 300    | 26 – 29     | 35 – 40        |
| 2.4                | 250 – 300    | 26 – 29     | 35 – 40        |