

## Classifications

DIN 8555

MF 10-GF-60-G

## Characteristics

High Chromium alloy designed to resist severe abrasive wear with moderate impacts. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides in an eutectic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 10 to 12 mm in 2 to 3 layers

## Field of use

Auger flights, guides, pump housings.

## Typical analysis in %

C	Mn	Si	Cr	Mo	B	Fe
3.7	0.3	1.1	32.0	0.5	0.2	balance

## Typical mechanical properties

Hardness as welded: 57 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40