

Classifications					
DIN 8555					
MF 6-GF-60-GP					
Characteristics					
Premium martensitic steel alloy designed for welding at low parameters in horizontal positions under gas shielding. Its resistance to friction and low stress abrasion wear with moderate impact is excellent.					
Microstructure:	Martensite				
Machinability:	Grinding only				
Oxy-acetylene cutting:	Flame cut is difficult				
Deposit thickness:	3,5 - 4,0 mm in one layer				
Shielding gas:	Argon 82 %+ CO ₂ 18 %				
Field of use					
Automatic surfacing of corners and edges of cutting tools.					
Typical analysis in %					
C	Mn	Si	Cr	Mo	Fe
0,4	1,2	0,8	6,0	0,7	balance
Typical mechanical properties					
Hardness as welded: 60 HRC					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]	
1,2	130-160	17-20	20 max.	12-15	