

Classifications

DIN 8555

MF 3-GF-60-GT

Characteristics

Martensitic steel alloy designed for welding in horizontal and vertical-up positions under gas shielding. Its resistance to friction and medium stress abrasive wear with moderate impact is excellent.

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82% + CO₂ 18% or CO₂ 100%

Field of use

Dies, sliding metal parts, bucket teeth, gear teeth, crusher hammers, impact drills, etc.

Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Fe
0,45	0,9	0,6	5,5	1,4	1,6	0,5	balance

Typical mechanical properties

Hardness as welded: 58 HRC

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