

## Classifications

DIN 8555

MF 5-GF-45

## Characteristics

Alloy depositing a ferritic-martensitic steel with addition of nitrogen designed to resist metal-to-metal wear, corrosion and thermal fatigue.

Microstructure: Martensite + ferrite

Machinability: Good with carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

## Field of use

Continuous casting rollers.

## Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	N	Fe
0.03	1.0	0.6	13.0	4.2	0.5	0.1	balance

## Typical mechanical properties

Hardness as welded: 44 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.4	250 – 300	25 – 26	35 – 40