

Classifications

DIN 8555

MF 5-GF-45-C

Characteristics

Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1 % Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure: Martensite + 10 % 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	Fe
0.02	0.6	0.6	12.6	5.2	0.8	balance

Typical mechanical properties

Hardness as welded: 43 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 29	35 – 40
2.4	250 – 300	26 – 29	35 – 40
2.8	300 – 350	26 – 29	35 – 40