

Classifications

DIN 8555

MF 6-GF-40-G

Characteristics

Medium carbide alloy designed primarily for heavy build – up using automatic processes. The deposits will readily stress relief crack.

Microstructure: Interdendritic eutectic carbides of the type, perlite, austenite partially transformed in bainite, few martensite

Machinability: Grinding only

Oxy – acetylene cutting: Cannot be flame cut

Deposit thickness: 15 to 20 mm

Field of use

Dredge pump shells, gyratory crusher mantles and bowls.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
1.9	1.5	1.8	9.0	1.4	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	150 – 250	26 – 30	35 – 40
2	200 – 300	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40