

Classifications					
DIN 8555					
MF 7-GF-200-KP					
Characteristics					
Austenitic alloy without Chromium designed for rebuilding 14 % Manganese steel parts where parent metal matching colour is a must.					
Microstructure:	Austenite				
Machinability:	Good with metallic carbide tipped tools				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	Depends upon application and procedure used				
Shielding gas:	Argon 82% + CO ₂ 18%				
Field of use					
Patching of Hadfield steel castings, crusher cylinders, crusher hammers, impactor bars.					
Typical analysis in %					
C	Mn	Si	Ni	Mo	Fe
0,9	14,5	0,3	2,0	0,5	balance
Typical mechanical properties					
Hardness as welded: 185 HB					
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	