

Classifications					
DIN 8555					
MF 10-GF-60-G					
Characteristics					
Hardfacing Chromium carbide alloy recommended for applications combining moderate stress abrasion with moderate impact. The deposit will readily show stress relief cracks.					
Microstructure:	Primary carbides and eutectic carbides, austenite				
Machinability:	Grinding only				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	2 to 3 layers maximum				
Field of use					
Wear plates, screw conveyors, shovel bucket teeth and lips, etc.					
Typical analysis in %					
C	Mn	Si	Cr	B	Fe
4.0	0.1	0.1	20.0	0.45	balance
Typical mechanical properties					
Hardness as welded: 59 HRC					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]	
1.2	120 – 150	26 – 30		35 – 40	
1.6	150 – 250	26 – 30		35 – 40	