

## Classifications

DIN 8555

MF 22-GF-45-G

## Characteristics

Hardfacing cored wire containing about 45% Tungsten carbide particles incorporated in a NiB matrix. This composition gives the best possible combination of toughness and abrasion resistance, also in corrosive conditions.

Microstructure: Tungsten carbides into an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Not possible

Deposit thickness: 6 mm in 2 layers maximum

Shielding gas: Argon 98 % + Oxygen 2%

## Field of use

Wheel excavator bucket teeth, brick and clay mill augers, wood chipper spout and bed knives in the paper industry and crusher rollers, dredging wear parts, etc.

## Typical analysis in %

C	Mn	Si	Ni	W	B	Fe
1,7	0,1	0,1	balance	41,5	0,8	1,1

## Typical mechanical properties

Hardness as welded: 46 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	170-220	19-23	20 max.	12-15