

Classifications

DIN 8555

MF 21-GF-65-G

Characteristics

Cored wire containing about 60 % Tungsten carbide particles. The composition and particle size have been optimized to provide the best combination of toughness and wear resistance. The deposit will readily show stress relief cracks.

Microstructure: 65 % Tungsten carbides
 35 % austenite + martensite

Machinability: Grinding only

Deposit thickness: 1 to 2 layers maximum

Field of use

Wheel excavator bucket teeth, concrete mixer blades, brick and clay mill augers, crusher rollers, wood chipper spouts and bed knives, dredging wear parts, etc.

Typical analysis in %

C	Mn	Si	Cr	W	Fe
2.9	0.4	0.4	5.8	42.0	balance

Typical mechanical properties

Hardness as welded: 63 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	125 – 200	19 – 24	35 – 40
2.0	140 – 250	19 – 24	35 – 40
2.4	150 – 300	19 – 24	35 – 40