

Classifications

DIN 8555

MF 10-GF-60-G

Characteristics

CrNb alloy with addition of Boron designed to resist high stress grinding and gouging abrasion. The deposit will readily show stress relief cracks.

Microstructure: Eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

Field of use

Bucket teeth and lips on bucket-wheel excavators in coal and phosphate mines, brick and clay mill augers, bucket teeth and lips on shovel buckets and bulldozer blades working in sand, crushing equipment, wear plates, screens in the coal industry, etc.

Typical analysis in %

C	Mn	Si	Cr	Nb	B
4.0	0.3	0.7	18.5	3.0	0.25

Typical mechanical properties

Hardness: 58 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.8	300 – 350	26 – 30	35 – 40