

Classifications

DIN 8555
MF 10-GF-65-G

Characteristics

CrNb alloy designed to resist high stress grinding abrasion at service temperature not exceeding 450 °C. The deposit will readily show stress relief cracks.

Microstructure:	Austenitic matrix with primary & eutectic carbides and nodular Nb carbides
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	10 to 12 mm in 2 to 3 layers

Field of use

Shovel, excavator, dredge and dragline bucket lips and teeth, hammers, rippers, crushing equipment, wear plates, expeller screws, giratory crushers, etc.

Typical analysis in %

C	Mn	Si	Cr	Nb	Fe
5.6	0.2	1.3	20.2	6.7	balance

Typical mechanical properties

Hardness as welded: 64 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40