

## Classifications

DIN 8555

MF 10-GF-65-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: Complex carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 2 layers maximum

## Field of use

Shovel, excavator, dredge and dragline bucket lips and teeth, hammers, ripper teeth, crushing equipment, expeller screws, giratory crushers, wear plates, screens in the coal industry, etc.

## Typical analysis in %

C	Mn	Si	Cr	Nb	B	Fe
5.2	0.2	1.0	20.3	6.7	1.0	balance

## Typical mechanical properties

Hardness as welded: 65 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	30 – 35
2.4	250 – 300	26 – 30	30 – 35
2.8	325 – 450	26 – 30	30 – 35