

## 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. Welding properties optimized for wear plates manufacturing.

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

Wear plates.

## 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]
2.8	300 – 350	26 – 30	35 – 40