

## Classifications

DIN 8555

MF 2-GF-65-G

## Characteristics

Hardfacing alloy giving an excellent resistance to medium stress abrasive wear with moderate impact. A very high hardness is already achieved in the first layer.

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends on application and procedure used

Shielding gas: Argon 98% + Oxygen 2%

## Field of use

Mixers and scrapers, excavator buckets, press screws parts.

## Typical analysis in %

C	Mn	Si	Ni	B	Fe
0,5	1,3	1,0	1,6	3,7	balance

## Typical mechanical properties

Hardness as welded: 62 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-250	20-31	20 max.	12-15
1,6	110-300	20-31	20 max.	15-20