

Classifications				
DIN 8555				
MF 1-GF-250-P				
Characteristics				
Open-arc wire for joining and rebuilding of mild and low alloy steels.				
Microstructure:	Ferrite			
Machinability:	Good			
Oxy-acetylene cutting:	Possible			
Deposit thickness:	As required			
Field of use				
Profiles, reels, roll construction and reparation, crane wheel.				
Typical analysis in %				
C	Mn	Si	Fe	
0.04	0.8	0.1	balance	
Typical mechanical properties				
Hardness as welded: 250 HB				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	
1.2	120 – 150	26 – 30	35 – 40	
1.6	180 – 200	26 – 30	35 – 40	
2.8	250 – 300	26 – 30	35 – 40	