

Classifications

DIN 8555

MF 1-GF-350-GP

Characteristics

Open-arc cored wire designed for rebuilding and hardfacing for Carbon steel parts.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Difficult

Deposit thickness: No restriction

Field of use

Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.08	0.9	0.7	2.3	2.0	1.0	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40