

Classifications									
DIN 8555									
MF 6-GF-50-C									
Characteristics									
Special alloy designed for the repair and the hard surfacing of extrusion tools.									
Microstructure:	Martensite								
Machinability:	By grinding only								
Oxy-acetylene cutting:	Cannot be flame cut								
Deposit thickness:	Depends upon application and procedure used								
Shielding gas:	Argon 98% + Oxygen 2% or Argon 100%								
Field of use									
Gum mixer shell.									
Typical analysis in %									
C	Mn	Si	Cr	Ni	Mo	Co	W	V	Fe
0,25	1,0	0,6	11,0	0,3	1,1	1,7	0,8	0,9	balance
Typical mechanical properties									
Hardness as welded: 50 HRC									
Recommended welding parameters									
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]					
1,6	250-450	20-31	20 max.	15-18					