

## Classifications

DIN 8555

MF 6-GF-50-CT

## Characteristics

Special Iron-Chromium-Cobalt-Molybdenum alloy designed to resist metal-to-metal wear, fatigue, oxidation, cavitation and corrosion at high temperature. The typical hardness can be achieved in the first layer.

Microstructure: Martensite + 15% ferrite (in first layer)

Machinability: Good with metallic carbide tipped tools

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

Continuous casting driving rollers, dies, mandrels, blanking punches, forming and punching tools, forging dies, swaging dies, pump elements.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Co	Fe
0,16	0,1	0,7	13,0	2,4	14,0	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]
1,2	200-300	25-31	20 max.	12-15
1,6	250-450	25-31	20 max.	15-18