

Classifications

DIN 8555

MF 23-GF-200-CKZ

Characteristics

NiCrMo alloy designed for hardsurfacing of parts subject to oxidation, corrosion and mechanical stresses at high temperature (1.100 °C). For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.

Microstructure: Solution of the austenitic type

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98% + Oxygen 2% or Argon 82% + CO₂ 18%

Field of use

Hot shear blades, pits points, mill guides, drawing guides, hot extrusion dies, blast furnace bell seats.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	W	Fe
0,05	1,0	0,2	16,0	balance	16,0	4,0	7,0

Typical mechanical properties

Hardness as welded: 195 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	17-32	20 max.	12-15
1,6	100-250	17-32	20 max.	15-18
2,4	200-450	20-31	20 max.	18-20