

## Classifications

DIN 8555

MF 22-GF-200-TZ

## Characteristics

Nickel-base super-alloy with high percentage of Cobalt providing the most powerful strengthening effect at high temperature due to the precipitation of Ni<sub>3</sub> (AlTi) phase.

Microstructure: Solid solution matrix containing carbides and Intermetallic precipitated Ni<sub>3</sub> (AlTi)

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

Rebuilding of GFM forging hammers.

## Typical analysis in %

C	Mn	Si	Cr	Ni	Co	Ti	Al	Fe
0,02	0,5	0,3	19,0	balance	18,0	2,7	1,4	2,0

## Typical mechanical properties

Hardness as welded: 190 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	150-250	20-31	20 max.	15-18
2,4	300-400	20-31	20 max.	15-20