

## Classifications

DIN 8555

MF 23-GF-200-TZ

## Characteristics

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

Microstructure: Solid solution with intermetallic precipitates 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%

Liner: A Teflon liner is advised

## Field of use

Rebuilding of forging hammers.

## Typical analysis in %

C	Si	Cr	Ni	Mo	Co	Ti	Al	Fe
0,01	0,3	18,5	balance	4,5	12,5	3,5	1,0	1,8

## Typical mechanical properties

Hardness as welded: 200 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	150-250	27-30	20 max.	15-20
1,6	200-300	27-30	20 max.	15-20