

Classifications

DIN 8555

MF 6-GF-70-GT

Characteristics

Special hardfacing cored wire designed to give an extreme resistance against high stress grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks.

Microstructure: Complex carbo-borides and borides homogeneously dispersed in the matrix

Oxy-acetylene cutting: Cannot be flame cut

Machinability: Grinding only

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Deposit Thickness: ca. 8 mm in maximum 2 layers

Shielding gas: Argon + 2 % Oxygen (if not used as open arc)

Field of use

Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.

Typical analysis

All Weld : C + Cr + Mo + Nb + W + V + B (Bal Fe)

Typical mechanical properties

Hardness as welded: 70 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 230	26 – 30	20 – 40
2.0	200 – 250	26 – 30	20 – 40
2.4	250 – 300	26 – 30	20 – 40
2.8	300 – 350	26 – 30	35 – 40