

<b>Classifications</b>					
DIN 8555		ASME IIC SFA 5.21			
MF 7-GF-200-KP		ERC FeMn-G			
<b>Characteristics</b>					
Self shielded flux cored wire depositing an austenitic alloy designed for rebuilding of 14 % Manganese steel parts.					
Microstructure:	Austenite				
Machinability:	Good with metallic carbide tipped tools				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	As required				
<b>Field of use</b>					
Crusher cylinders, crusher hammers, impactor bars.					
<b>Typical analysis in %</b>					
C	Mn	Si	Cr	Ni	Fe
0.9	14.0	0.5	3.5	0.4	balance
<b>Typical mechanical properties</b>					
Hardness as welded: 200 HB					
<b>Recommended welding parameters</b>					
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]	
1.2	120 – 180	26 – 30		35 – 40	
1.6	180 – 200	26 – 30		35 – 40	
2.4	250 – 300	26 – 30		35 – 40	
2.8	300 – 350	26 – 30		35 – 40	