

Classifications				
DIN 8555		ASME IIC SFA 5.21		
MF 1-GF-225-GP		ERC Fe-1		
Characteristics				
Metal-cored wire designed for building-up by welding in horizontal and vertical-up positions under gas shielding.				
Microstructure:	Ferrite + Pearlite			
Machinability:	Good			
Oxy-acetylene cutting:	Possible			
Deposit thickness:	Depends upon application and procedure used			
Shielding gas:	Argon 82% + CO ₂ 18%			
Field of use				
Conveyor chains, sliding metal parts, gear teeth, shafts.				
Typical analysis in %				
C	Mn	Si	Cr	Fe
0,09	1,2	0,5	0,4	balance
Typical mechanical properties				
Hardness as welded: 225 HB				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	10-18
1,6	150-250	20-31	20 max.	10-18