

Classifications					
DIN 8555		ASME IIC SFA 5.21			
MF 10-GF-60-G		FeCr-A9			
Characteristics					
Self shielded cored wire designed to deposit an alloy resistant to high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.					
Microstructure:	Primary carbides and eutectic carbides in an austenitic matrix				
Machinability:	Grinding only				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	8 to 10 mm maximum in 2 to 3 layers				
Field of use					
Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.					
Typical analysis in %					
C	Mn	Si	Cr	B	Fe
5.0	0.6	1.0	27.0	0.5	balance
Typical mechanical properties					
Hardness as welded: 60 HRC					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]		Voltage [V]		Stick-Out [mm]
1.2	125 – 180		26 – 30		35 – 40
1.6	180 – 200		26 – 30		35 – 40
2	200 – 250		26 – 30		35 – 40
2.4	250 – 300		26 – 30		35 – 40