

Classifications

DIN 8555

MF 7-GF-200/450-KP

Characteristics

Self shielded flux cored wire depositing an austenitic alloy designed for rebuilding 14% Manganese steel parts.

Microstructure: Austenite

Machinability: Good with carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Field of use

Railway rails and crossovers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0.9	14.0	0.5	0.5	0.5	balance

Typical mechanical properties

Hardness as welded: 195 HB

Recommended welding parameters

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