

Classifications

DIN 8555

MF 1-GF-40-P

Characteristics

Open-arc wire designed for rebuilding and hard surfacing of Carbon steel parts subjected to adhesive wear with impacts.

Microstructure: Bainite + Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Field of use

Crawler tractor rollers and idlers, shafts, cylinders, mine car wheels, crane wheels.

Typical analysis in %

C	Mn	Si	Cr	Ti	Fe
0.11	0.6	0.6	2.4	0.9	balance

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	120 – 150	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