

Classifications

DIN 8555

MF 5-GF-50-C

Characteristics

Alloy depositing a ferritic-martensitic steel designed to resist metal-to-metal wear, corrosion and thermal fatigue.

Microstructure: Martensite, little ferrite (10 %)

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Field of use

Continuous casting rollers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	V	Ti	Fe
0.19	0.8	0.7	13.0	2.2	1.0	0.35	0.25	balance

Typical mechanical properties

Hardness as welded: 48 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40