

Classifications					
DIN 8555					
MF6-GF-55-C					
Characteristics					
Alloy depositing a martensitic steel containing 12% chromium with molybdenum giving a good resistance to metal-to-metal wear and corrosion					
Microstructure:	Martensite				
Machinability:	Fair with carbide tipped tools				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	Depends upon application and procedure used				
Shielding gas:	Argon 98% + Oxygen 2%				
Field of use					
Dredging pump casings, continuous casting rolls...					
Typical analysis in %					
C	Mn	Si	Cr	Mo	Fe
0,24	1,0	0,4	12,0	0,7	balance
Typical mechanical properties					
Hardness as welded: 54 HRC					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]	
1,2	150-250	20-31	20 max.	12-15	