

## Classifications

DIN 8555

MF 6-GF-55-C

## Characteristics

Alloy depositing a martensitic steel containing 13 % Chromium giving a good resistance to metal-to-metal wear and corrosion.

Microstructure: Martensite

Machinability: Good with cubic Boron Nitride tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

## Field of use

Dredging pump casings, continuous casting rollers.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.4	0.7	0.2	13.5	0.2	balance

## Typical mechanical properties

Hardness as welded: 54 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40