

Classifications

DIN 8555	ASME IIC SFA 5.21
MF 1-GF-450-GP	ERC Fe-2

Characteristics

Rebuilding and hardfacing alloy designed for welding in horizontal and vertical-up positions under gas shielding.

Microstructure: Martensite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82% + CO₂ 18% or CO₂ 100%

Field of use

Undercarriage rollers and idlers, crane wheels, sealing rings seats.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0,27	1,1	0,2	2,3	0,5	balance

Typical mechanical properties

Hardness as welded: 47 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18