

Classifications

DIN 8555

MF 6-GF-50-GT

Characteristics

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

Microstructure: Martensite

Machinability: Grinding only

Oxy-acetylene cutting: Flame cut is difficult

Deposit thickness: Depends upon application and procedure used

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

Field of use

Undercarriage rollers and idlers, shovel teeth, shear blades.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0,26	1,3	0,7	5,0	0,5	balance

Typical mechanical properties

Hardness as welded: 52 HRC

Recommended welding parameters

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