

<b>Classifications</b>						
DIN 8555						
MF 7-GF-250-GKP						
<b>Characteristics</b>						
High Chromium – Manganese alloy enriched with Niobium, designed to resist abrasion and solid erosion wear combined with heavy impact. High Manganese alloy resulting in a workhardenable deposit.						
Microstructure:	Dispersed Niobium and Chromium carbides in an austenitic matrix					
Machinability:	Good with metallic carbides or cubic Boron Nitride tipped tools					
Oxy – acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Depends upon application and procedure used					
<b>Field of use</b>						
Crusher hammers, gyratory crusher mantles, crusher cylinders, automobile shredder hammers.						
<b>Typical analysis in %</b>						
C	Mn	Si	Cr	Nb	Ti	Fe
1.0	17.2	0.3	8.2	2.5	0.12	balance
<b>Typical mechanical properties</b>						
Hardness as welded: 240 HB						
<b>Recommended welding parameters</b>						
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	