

Classifications

DIN 8555

MF 10-GF-60-G

Characteristics

Alloy designed to resist high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides and eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

Field of use

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth, wear plates.

Typical analysis in %

C	Mn	Si	Cr	B	Fe
4.5	0.7	0.8	27.0	0.5	balance

Typical mechanical properties

Hardness as welded: 60 HRC

Recommended welding parameters

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