

Classifications

DIN 8555

MF 9-GF-250-CT

Characteristics

Alloy providing a strengthening effect at high temperature due to the precipitation of intermetallic components. Special hardfacing iron base alloy designed to resist general corrosion, frictional wear, cavitation, high surface pressures and suitable for applications where a low friction coefficient is profitable.

Microstructure: Austenite + Ferrite + some chromium carbides at the grain boundaries

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Shielding gas: Argon 98% + Oxygen 2%

Field of use

Hardfacing of the sealing faces of valves and fittings, casings, chutes, slideways, mixer parts, mixer blades.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe
0,06	1,9	5,6	17,0	8,3	balance

Typical mechanical properties

Hardness as welded: 250 HB After PWHT (2h) at 650°C: 33 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	200-300	21-30	15-20	15-18
2,8	300-350	21-30	15-20	20-22