

Classifications

DIN 8555

MF 1-GF-300-P

Characteristics

Rebuilding alloy for Carbon steel parts. Can also be used as buffer layer prior to hard overlay.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: Depends upon application and procedure used

Field of use

Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0.1	0.9	0.6	0.5	0.3	balance

Typical mechanical properties

Hardness as welded: 280 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	120 – 150	26 – 30	35 – 40
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40