

Standards

DIN 8555	MF10-GF-65-GZ
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Characteristics

C-, Cr-, B-, W-, V-alloyed flux-cored wire that deposits a very hard martensitic micro structure with carbides. The deposit is resistant against strong mineral abrasion at higher temperatures. The hardness decreases about 15 % at 400°C, about 25% at 600°C.

Best results are achieved by welding in two layers.

A maximum deposit thickness of 8 mm is recommended.

The resulting deposits cannot be heat-treated, machined or forged.

Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications

mineral and brick industry, impeller , mixer parts, scrapers

Mechanical properties of all-weld metal (typical values)

Hardness HRC	Hardness HRC at 400° C	Hardness HRC at 600° C
approx. 63	approx. 53	approx. 47

Weld metal analysis (typical, wt. %)

C	Cr	V	W	B
3,8	22	0,8	0,8	1,0

Gas types EN 439

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
1,2	3/64	19 - 22	120 - 220		
1,6	1/16	20 - 26	160 - 260	O	
2,0	5/64	22 - 27	220 - 280	O	
2,4	3/32	24 - 28	260 - 340	O	
2,8	7/64	25 - 29	300 - 400	O	S
3,2	1 / 8	26 - 30	320 - 460	O	S

Delivering form

O = Flux cored wire self shielding

G = Flux cored wire for shielded arc welding

S = Flux cored wire for submerged arc welding

Coiling / Weight

B/BS 300 = 15 kg

B 450 = 30 kg

Pay off pack = 150/ 300 kg

Rev. 000