

Standards

DIN 8555	MF10-GF-65-GZ
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Characteristics Very high C-, Cr-, B-alloyed flux-cored wire electrode for extreme hard and non-corrosive hardfacing against very high mineral wear also at high temperatures. The weld deposit has a ledeburitic structure, bearing many various hypereutectic carbides. A maximum deposit thickness of 1-2 layers is recommended. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications Annealing coke and slag, screens, pulverize hammers

Mechanical properties of all-weld metal (typical values)	Hardness HRC 20 °C		
	approx. 67		

Weld metal analysis (typical, wt. %)	C	Si	Cr	B
	5,0	0,8	38,0	2,0

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	G
	2,0	5/64	22 - 27	220 - 280	O	G
	2,4	3/32	24 - 28	260 - 340	O	G
	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