

## Classifications

EN 14700

DIN 8555

T Z Fe8

MF 6-GF-70-GT

## Characteristics

Special hardfacing cored wire designed to give an extreme resistance against high-stress-grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks.

Microstructure: Complex carbo-borides and borides homogeneously dispersed in the matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: ca. 8 mm in maximum 2 layers

Shielding gas: Argon + 2% Oxygen (if not used as open arc)

## Field of use

Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.

## Typical analysis in %

C + Cr + Mo + Nb + W + V + B (Bal Fe)

## Typical mechanical properties

Hardness as welded: 70 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	130-180	22-26	15-25
1.6	180-230	26-30	20-35