

## Classifications

EN 14700

DIN 8555

T Z Fe10

MF 8-GF-150/400-KPZ

## Characteristics and typical fields of application

Austenitic alloy type 18Cr8Ni7Mn recommended for build up and buffer layer prior to hardfacing. It can also be used for joining of dissimilar metals.

Microstructure: Austenite

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Field of use: Joining of wear plates on shovel buckets, railways and tramway lines, press rams, joining stainless steels to carbon manganese steels, building up and buttering before hardfacing, welding of 14 % Mn steels, armour and hard to weld steels.

## Typical analysis

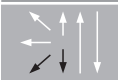
	C	Si	Mn	Cr	Ni	Fe
wt.-%	0.09	0.9	6.0	18.2	8.0	bal.

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
u	160

u - untreated, as welded

## Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	NO GAS		1.2	120-150
Stick-Out		35-40 mm	1.6	180-200	26-30
			2.0	200-250	26-30
			2.4	250-300	26-30
			2.80	300-350	26-30

## Approvals

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