

CLASSIFICATIONS

EN 14700 : T Fe8
DIN 8555 : MF 10-GF-55-GP

DESCRIPTION

- FC wire containing C, Cr, Ti and Mo alloys
- Weld metals with martensitic microstructure including titanium carbide
- High resistance to wear and to impact
- Machinability of weld metal through grinding
- Best suited for applications involving extreme wear under high pressure
- Shielding Gas: Open Arc

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 1.80 | Si: 1.5 | Mn: 2.0 | Cr: 7.0 | Mo: 1.4 | Ti: 5.0 | Fe: Rest

MECHANICAL PROPERTIES

Hardness (As Welded)
(HRC)

52 - 57

BASE MATERIALS

- Roller presses, grinding/pulverizing rolls, dredge pump shells, rock crushing hammers, shredders, asphalt, kneaders, crushing hard materials, vertical shaft impact crusher rotors, roller presses.

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 30.0	25.0 - 30.0
2.80	300 - 500	25.0 - 30.0	25.0 - 30.0

CURRENT TYPE

FCAW / D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
1011100233	1.60	1/16	15
1011100234	2.80	7/64	25