

## CLASSIFICATIONS

EN 14700 : T Fe15  
DIN 8555 : MF 10 GF-65-G

## DESCRIPTION

- Extremely high hardness with specially-proportioned chemical composition including high amounts of C, Cr, Nb, B. High strength to abrasion provided by the special chemical composition
- Shielding Gas : Open Arc

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 5.2 | Si: 1.3 | Mn: 0.4 | Cr: 22.0 | Nb: 7.0 | B: 1.0 | Fe: Rest

## MECHANICAL PROPERTIES

**Hardness** (As Welded)  
(HRC)

62 - 65

## BASE MATERIALS

- Hardfacing of mining equipments, augers, impellers, dredgers, drills, gearwheels and parts. Fan blades, excavator scoops, bucket lips and wear plates

## WELDING POSITIONS



## OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	25.0 - 30.0

## CURRENT TYPE

FCAW / D.C. (+)

## OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
1011100237	1.60	1/16	15