

CLASSIFICATIONS

EN 14700 : T Fe 15
DIN 8555 : MF 10-GF-60 G

DESCRIPTION

- Open arc, hardfacing flux cored wire with Cr-Carbides
- It is suitable for low alloyed steel and carbon steels
- Weld metal is very hard and it is common to have transverse cracks on weld seam
- Max. two passes can be weld with this wire

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 5.0 | Si: 1.5 | Mn: 1.3 | Cr: 27.0 | Fe: Rest

MECHANICAL PROPERTIES

Hardness (As Welded)
(HRC)

60 - 64

BASE MATERIALS

- Ventilators, wear plates, crushers for soft materials, shredders, chemical and food processing industries.

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	20.0 - 25.0
2.80	300 - 500	25.0 - 31.0	20.0 - 25.0

CURRENT TYPE

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
1011100235	1.60	1/16	15
1011100236	2.80	7/64	25