

CLASSIFICATIONS

EN 14700 : T Fe8
DIN 8555 : MF 6 GF 55 GT

DESCRIPTION

- This hardfacing flux cored wire has excellent wear resistance and keeps its strength at high temperatures
- Used in cold and hot work tool steels, hot shape knives, extrusion die and steel casting and dies
- Shielding gas : M21

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.65 | Si: 0.50 | Mn: 1.55 | Cr: 7.20 | Mo: 1.00 | W: 1.60 | V: 0.10

MECHANICAL PROPERTIES

Hardness (As Welded)
(HRC)

53 - 56

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.20	150 - 220	26 - 30	20 - 25

CURRENT TYPE

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
2010300034	1.20	0.047"	15