

Classifications

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|-----------------|-----------------|
| DIN 8555 | EN 14700 |
| MSG 10-GF-60CGP | T Fe 15 |

Characteristics and typical fields of application

Seamless high chromium alloyed metal-cored wire for surfacing applications with Ar-CO₂ shielding gases or even without shielding gas protection. The alloy designed to resist high stress grinding abrasion with low impact. The deposits can show stress relief cracks. In order to minimize the dilution with the base material it is recommended to weld stringer beads with an overlap of 50 %.

Field of use: parts of earth moving machinery, rollers, mills and cement applications

Typical analysis

| | Gas | C | Si | Mn | Cr | Nb |
|-------|-----|-----|-----|-----|----|-----|
| wt.-% | M21 | 3.5 | 0.8 | 0.2 | 22 | 0.4 |

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

| Condition | Hardness |
|--------------------------|----------|
| | Hardness |
| u | 57 - 62 |
| u - untreated, as welded | |

Operating data

|  | Polarity | DC+ | Dimension mm |
|--|------------------------------|-----------|--------------|
| | Shielding gas (EN ISO 14175) | M21 / M12 | 1.6 |
| | | | 2.4 |

Approvals

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