

Classifications

EN 14700

DIN 8555

T Fe7

MF 5-GF-400-C

Characteristics

Self shielded cored wire depositing a ferritic-martensitic steel designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.

Microstructure: Martensite + 10 % Ferrite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Up to 4 layers

Field of use

Hardfacing of continuous casting rollers.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	Fe
0.03	0.5	0.6	15.5	5.2	0.5	balance

Typical mechanical properties

Hardness as welded: 42 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.0	200 – 300	26 – 30	30 – 35
2.4	250 – 360	26 – 30	30 – 35