

## Classifications

EN 14700

DIN 8555

T Fe16

MF 10-GF-60-G

## Characteristics

Self-shielded cored wire designed to deposit an alloy resistant to high stress grinding abrasion with low impact. The deposits will readily show stress relief cracks.

Microstructure: Primary carbides and eutectic carbides in an austenitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 8 to 10 mm maximum in 2 to 3 layers

## Field of use

Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth.

## Typical analysis in %

| C   | Mn  | Si  | Cr   | B   | Fe      |
|-----|-----|-----|------|-----|---------|
| 4.5 | 0.6 | 0.7 | 27.0 | 0.5 | balance |

## Typical mechanical properties

Hardness as welded: 60 HRC

## Recommended welding parameters

| Wire diameter [mm] | Amperage [A] | Voltage [V] | Stick-Out [mm] |
|--------------------|--------------|-------------|----------------|
| 1.2                | 125 – 180    | 26 – 30     | 35 – 40        |
| 1.6                | 180 – 200    | 26 – 30     | 35 – 40        |