

**Standards**

|          |                |
|----------|----------------|
| DIN 8555 | MF10-GF-65-RGZ |
|----------|----------------|

**Characteristics** Tubular wire for hardfacings, resistant to extreme abrasive wear, even at high temperatures. The deposit has a ledeburitic structure, bearing a lot of different very hard carbides. The wire is used, wherever abrasive wear is extremely high even at temperatures up to 800°C. The deposit is free of slag, weldability is excellent. Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits cannot be heat-treated, machined or forged. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

**Typical applications** Concrete-industry, mixer parts, scrapers

|   |                               |
|---|-------------------------------|
| <b>Mechanical properties of all-weld metal (typical values)</b> | <b>Hardness HRC<br/>20 °C</b> |
|   | 64- 67                        |

|   |          |           |           |           |          |
|---|----------|-----------|-----------|-----------|----------|
| <b>Weld metal analysis (typical, wt. %)</b> | <b>C</b> | <b>Si</b> | <b>Cr</b> | <b>Nb</b> | <b>B</b> |
|   | 5,2      | 0,8       | 32,5      | 5,5       | 1,5      |

**Gas types EN 439** ---

**Current** = +

| <b>Current intensity</b> | <b>DIA (mm)</b> | <b>DIA (inch)</b> | <b>Volt</b> | <b>Amps</b> | <b>Delivering form</b> |          |
|--------------------------|-----------------|-------------------|-------------|-------------|------------------------|----------|
|                          | 1,2             | 3/64              | 19 - 22     | 120 - 220   |                        |          |
|                          | 1,6             | 1/16              | 20 - 26     | 160 - 260   | <b>O</b>               |          |
|                          | 2,0             | 5/64              | 22 - 27     | 220 - 280   | <b>O</b>               |          |
|                          | 2,4             | 3/32              | 24 - 28     | 260 - 340   | <b>O</b>               |          |
|                          | 2,8             | 7/64              | 25 - 29     | 300 - 400   | <b>O</b>               | <b>S</b> |
|                          | 3,2             | 1 / 8             | 26 - 30     | 320 - 460   | <b>O</b>               | <b>S</b> |

**Delivering form**  
**O = Flux cored wire self shielding**  
**G = Flux cored wire for shielded arc welding**  
**S = Flux cored wire for submerged arc welding**

**Coiling / Weight** B/BS 300 = 15 kg      B 450 = 30 kg      Pay off pack = 150/ 300 kg

Rev. 000