

Standards

DIN 8555	MF10-GF-65-RGZ
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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

Mechanical properties of all-weld metal (typical values)	Hardness HRC
	20 °C
	64- 67

Weld metal analysis (typical, wt. %)	C	Si	Cr	Nb	B
	5,2	0,8	32,5	5,5	1,5

Gas types EN 439 ---

Current = +

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

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