

Standards

DIN 8555	MF10-GF-65-GZ
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Characteristics C-, Cr-, Mo, V-, B-alloyed flux-cored wire electrode for extreme mineral wear. The weld deposit has a high scratch hardness. Applications are sinter plants, lignite mining machines, gravel industry, chains, etc. 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 Mining and clinker industry, concrete pumps.

Mechanical properties of all-weld metal (typical values)

Hardness HRC 20 °C
63

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo	V	B
5	1,3	1	28-30	2	2	2

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	
2,0	5/64	22 - 27	220 - 280	
2,4	3/32	24 - 28	260 - 340	O
2,8	7/64	25 - 29	300 - 400	O
3,2	1 / 8	26 - 30	320 - 460	

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