

Standards

DIN 8555	MF10-GF-50-G
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Characteristics C-, Cr-, Si-, Mn- alloyed flux cored wire on parts which subjected to abrasive wear and medium impact

Typical applications Abrasive wear in combination with medium impact

Working temperature

Hardness of pure deposits

as welded (HRc)
Ca. 52

Weld metal analysis

C	Si	Mn	Cr
3,0	1,8	1,8	15,0

(typical, wt. %)

Gas types EN 439 ---

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
	1,2	3/64	19 - 22	120 - 220	O	
	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

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150 / 300 kg

Rev. 000