

## Specification

<b>DIN 8555</b>	<b>EN 14700</b>
<b>MF 10-GF-60-G</b>	<b>T Fe15 - 60</b>

## Characteristics and Field of application

The deposit will show readily stress relief cracks, is suitable to hardfacing of Gyratory crushers cones and mantles, vertical roller mills, coal pulverizer rolls, Palm oil expeller screws, groundnut oil expeller screws, cement conveyors screws, catalytic pipes, dredge pump impellers, dredge cutters, shovel bucket teeth, among other.

**Microstructure:** Primary Carbides and M7C3 eutectic carbides in an austenitic matrix.

**Machinability:** Grinding Only.

**Oxy-acetylene cutting:** Cannot be flame cut.

**Deposit Thickness:** 10 to 15 mm maximum in 3 layers.

## Hardness of the deposit

Hardness as welded: 63 Rc

## Weld metal analysis in %

C	Mn	Si	Cr	B	Fe
4.50	0.07	0.80	24.5	0.60	Resto

## Welding Instructions

Hold flux cored wire as vertically as possible, Preheating is in general not necessary. On multipass-applications a base layer with UTP 630 or UTP AF 402-O is recommended in order to prevent hardening cracks in the weld deposit.

## Welding Positions

## Current Type

Direct Current / positive electrode (DC = +)



## Welding Parameters

Diámetro (mm)	1.6	2.4	2.8
Amperage (A)	180 - 220	250 - 300	300 - 350
Voltaje (V)	26 - 29	26 - 30	26 - 30
Stick - out (mm)	35 - 40	35 - 40	35 - 40

## Packaging

Standard presentation	Other presentations
Spool of 33.06 lbs.(15 Kgs.)	Ask our technical representative availability

Due to the continuous improvement of consumables, we reserve the right to change the information contained in this data sheet without notice. Details concerning the application are for the purpose of guiding the user. The user is fully responsible for the proper use of these products to comply with the standards, specifications, maintenance procedures and building codes, manufacture, assembly or repair applicable.