

## Classifications

<b>EN 14700</b>	<b>DIN 8555</b>
T Fe13 mod.	MF 1-GF-300-P

## Characteristics and typical fields of application

Rebuilding alloy for Carbon steel parts. Can also be used as buffer layer prior to hard overlay.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Possible

Deposit thickness: Depends upon application and procedure used

Field of use: Crawler tractor links, crane wheels, shafts, buffer layer for continuous casting rollers, mine car wheels.


## Typical analysis

	C	Si	Mn	Cr	Mo	Fe
wt.-%	0.09	0.6	1.0	0.5	0.3	bal.

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
u	275
u - untreated, as welded	

## Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	NO GAS	1.2	120-150	26-30
	Stick-Out	35-40 mm	1.6	180-200	26-30
		2.0	200-250	26-30	
		2.4	250-300	26-30	
		2.8	300-350	26-30	

## Approvals

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