

Classifications

EN 14700	DIN 8555
T Z Fe8	MF 6-GF-70-GT

Characteristics

Special hardfacing cored wire designed to give an extreme resistance against high-stress-grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks.

Microstructure:	Complex carbo-borides and borides homogeneously dispersed in the matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	ca. 8 mm in maximum 2 layers
Shielding gas:	Argon + 2% Oxygen (if not used as open arc)

Field of use

Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.

Typical analysis in %

C + Cr + Mo + Nb + W + V + B (Bal Fe)

Typical mechanical properties

Hardness as welded: 70 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	130-180	22-26	15-25
1.6	180-230	26-30	20-35