

Standards

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| DIN 8555 | MF10-GF-70-GZ |
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Characteristics C-, Cr-, V-, Nb-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 |
|-----------------------|
| 67 |

Weld metal analysis (typical, wt. %)

| C | Si | Cr | Nb | V | B |
|-----|-----|----|-----|-----|-----|
| 5,5 | 1,3 | 16 | 6,5 | 6,0 | 1,0 |

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 | 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

Coiling / Weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150 / 300 kg
Rev. 000