

Standards

DIN 8555	MF 22-60-CGTZ
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Characteristics

Ni-, Si-, Cr-, B-alloy. which leaves a nickel-base weld deposit. The essential characteristics correspond to the Cobalt-base alloys, especially the hardness, corrosion resistance, heat resistance, wear resistance and thermal shock constancy. Applications are found in the chemical industry, nuclear technology field, etc.

Typical applications

Fittings, chemical industry, food industry, nuclear technology, extrusion screws

Hardness of pure deposits

as welded (HRc)
55 – 60

Weld metal analysis
(typical, wt. %)

C	Si	Cr	Ni	B	Fe
0,75	4,2	13,5	Base	3,0	<5

Gas types EN 439

I1, M13: 98 – 99 % Argon with 1 – 2 % Oxygen

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	G
2,0	5/64	22 - 27	220 - 280	G
2,4	3/32	24 - 28	260 - 340	G
2,8	7/64	25 - 29	300 - 400	
3,2	1 / 8	26 - 30	320 - 460	

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