

Classifications						
DIN 8555						
MF 6-GF-50-CT						
Characteristics						
Special Iron-Chromium-Cobalt-Molybdenum alloy designed to resist metal-to-metal wear, fatigue, oxidation, cavitation and corrosion at high temperature. The typical hardness can be achieved in the first layer.						
Microstructure:	Martensite + 15% ferrite (in first layer)					
Machinability:	Good with metallic carbide tipped tools					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 98 % + Oxygen 2% or Argon 100%					
Field of use						
Continuous casting driving rollers, dies, mandrels, blanking punches, forming and punching tools, forging dies, swaging dies, pump elements.						
Typical analysis in %						
C	Mn	Si	Cr	Mo	Co	Fe
0,16	0,1	0,7	13,0	2,4	14,0	balance
Typical mechanical properties						
Hardness as welded: 50 HRC						
Recommended welding parameters						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]		
1,2	200-300	25-31	20 max.	12-15		
1,6	250-450	25-31	20 max.	15-18		