

Classifications

EN 14700	DIN 8555	ASME IIC SFA 5.21
T Fe9	MF 7-GF-200-KP	FeMn-Cr

Characteristics and typical fields of application

Multi-purpose cored wire, mainly used for rebuilding and joining of Carbon and 14 % Manganese steels. Can also be used as buffer layer prior to hard overlay. Work-hardenable alloy.

Microstructure: Austenite Machinability: Good with metallic carbides tipped tools

Oxy-acetylene cuttin: Cannot be flame cut

Deposit thickness: As required

Field of use: Railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, repointing of shovel teeth, buffer layer for inter-particles crushers.

Typical analysis

	C	Si	Mn	Cr	Fe
wt.-%	0.38	0.4	16.0	13.0	bal.

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

Condition	Hardness
	HB
u	200

Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V			
	Shielding gas (EN ISO 14175)	NO GAS						
	Stick-Out	35-40 mm						
						1.2	120-150	26-30
						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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