

Classifications

DIN 8555	ASME IIC SFA 5.21
MF 7-GF-200-KP	FeMn-Cr

Characteristics

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. Enhanced feedability and weldability.

Microstructure:	Austenite
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	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 in %

C	Mn	Si	Cr	Fe
0.39	16.3	0.4	12.9	balance

Typical mechanical properties

Hardness as welded: 205 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40