

## Classifications

|                    |          |
|--------------------|----------|
| DIN 8555           | EN 14700 |
| MSG 6 - GF - 60 GP | T Fe 8   |

## Characteristics and typical fields of application

Seamless, Chromium-Molybdenum alloyed, metalcored wire for wear resistant hardfacing applications up to 700°C with Ar-CO<sub>2</sub> shielding gas. For steels that are difficult to weld, a buffer layer using KB 1 basic flux cored wire should be applied. HRC 57-62

## Base materials

Not applicable

## Typical analysis of all-weld metal (wt.-%)

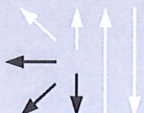
| C    | Mn   | Si   | P       | S       | Cr   | Mo   | Gas |
|------|------|------|---------|---------|------|------|-----|
| 0.50 | 1.50 | 0.60 | < 0.025 | < 0.025 | 5.50 | 0.60 | M21 |

## Mechanical properties of all-weld metal – typical values (minimum values)

| Condition | Yield strength<br>R <sub>p0.2</sub> | Tensile strength<br>R <sub>m</sub> | Elongation<br>A (L <sub>0</sub> =5d <sub>0</sub> ) | Impact work |   |
|-----------|-------------------------------------|------------------------------------|----------------------------------------------------|-------------|---|
|           | MPa                                 | MPa                                | %                                                  | -           | - |
| u         | -                                   | -                                  | -                                                  | -           | - |

u: untreated, as welded – shielding gas Ar + 18% CO<sub>2</sub>

## Operating data

|  | Ø (mm) | Current A | Voltage V |
|-------------------------------------------------------------------------------------|--------|-----------|-----------|
|                                                                                     | 1.00   | 40 - 270  | 11 - 32   |
|                                                                                     | 1.20   | 50 - 320  | 12 - 35   |
|                                                                                     | 1.40   | 60 - 380  | 14 - 36   |
|                                                                                     | 1.60   | 60 - 420  | 16 - 38   |
|                                                                                     | 2.00   | 100 - 450 | 17 - 40   |
|                                                                                     | 2.40   | 150 - 500 | 18 - 42   |