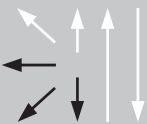


Classifications							
DIN 8555				EN 14700			
MSG 6 - GF - 60 GP				T Fe 8			
Characteristics and typical fields of application							
Seamless, Chromium-Molybdenum alloyed, metalcored wire for wear resistant hardfacing applications up to 700°C with Ar-CO ₂ shielding gas. For steels that are difficult 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 R _{p0.2}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)	Impact work		
	MPa	MPa		%	-	-	
u	-	-		-	-	-	
u: untreated, as welded – shielding gas Ar + 18% CO ₂							
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			