

Classifications						
DIN 8555						
MF 6-GF-60-GP						
Characteristics						
Martensitic steel alloy designed for welding in horizontal and vertical-up positions under gas shielding. Its resistance to friction and low stress abrasive wear with moderate impact is excellent.						
Microstructure:	Martensite					
Machinability:	Grinding only					
Oxy-acetylene cutting:	Flame cut is difficult					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 82% + CO ₂ 18% or CO ₂ 100%					
Field of use						
Bucket teeth, gravel pumps, conveyor chains, sliding metal parts, gear teeth, crusher hammers, rock drills						
Typical analysis in %						
C	Mn	Si	Cr	Mo	Ti	Fe
0,52	1,5	1,2	5,9	0,8	0,05	balance
Typical mechanical properties						
Hardness as welded: 59 HRC						
Recommended welding parameters						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate[L/min]		
0,9	80-170	17-30	20 max.	12-15		
1,2	110-180	20-31	20 max.	12-15		
1,6	150-250	20-31	20 max.	15-18		