

<b>Classifications</b>						
DIN 8555						
MF 5-GF-40-C						
<b>Characteristics</b>						
Alloy depositing a ferritic-martensitic steel containing 13% Chromium, 5% Nickel and 1% Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking.						
Microstructure:	Martensite + 10% Ferrite					
Machinability:	Good with carbide tipped tools					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 98% + Oxygen 2%					
<b>Field of use</b>						
Surfacing of continuous casting rollers of very small diameters (<150mm).						
<b>Typical analysis in %</b>						
C	Mn	Si	Cr	Ni	Mo	Fe
0,06	0,5	0,6	13,0	5,5	0,8	balance
<b>Typical mechanical properties</b>						
Hardness as welded: 41 HRC						
<b>Recommended welding parameters</b>						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]		
1,2	110-180	20-31	20 max.	10-18		
1,6	150-250	20-31	20 max.	10-18		
2,4	250-350	20-31	20 max.	10-18		