

## 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.

Microstructure:	Austenite
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	As required
Shielding gas:	Argon 98% + Oxygen 2%

## 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
0,4	17,0	0,3	12,0	balance

## Typical mechanical properties

Hardness as welded: 200 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	150-250	20-31	20 max.	12-15