

## Classifications

DIN 8555

MF 4-GF-60-S

## Characteristics

Special alloy designed to deposit a molybdenum-alloyed high-speed steel. To avoid cracking, a minimum interpass temperature of 300°C should be applied.

Microstructure: Precipitated fine carbides in a martensitic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98 % + Oxygen 2%

## Field of use

Cutting edges of carbon steel tools, cold shear blades, lathe tools, guides, milling cutter, punching, drilling and stamping tools.

## Typical analysis in %

C	Mn	Si	Cr	Mo	W	V	Fe
1,2	0,4	0,4	4,5	8,0	1,8	1,7	balance

## Typical mechanical properties

Hardness as welded: 60 HRC

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	200-300	26-30	20 max.	12-15
1,6	250-450	26-30	20 max.	15-18