

Classifications					
DIN 8555					
MF 1-GF-350					
Characteristics					
Special alloy suitable for repair of tool steel parts working at high temperatures. The deposit is particularly resistant against cracks propagation.					
Microstructure:	Bainite + Martensite				
Machinability:	Good				
Oxy-acetylene cutting:	Possible				
Deposit thickness:	No restriction				
Shielding gas:	Argon 98% + Oxygen 2%				
Field of use					
Large casting parts, forging matrix, etc.					
Typical analysis in %					
C	Mn	Si	Cr	Ni	Fe
0,09	0,8	0,3	2,9	2,4	balance
Typical mechanical properties					
Hardness as welded: 330 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]	
1,6	200-280	26-31	20 max.	15-20	