

Classifications

DIN 8555	MSG 10-GF-65-G
EN 14700	T Fe 13

Characteristics and field of use

Seamless, Chromium - Nickel - Boron alloyed, metalcored wire for hardfacing using Ar-CO₂ shielding gas. The weld metal characteristics and structure is similar to hard chrome alloys. Excellent resistance to abrasion induced by sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The deposit will readily show stress relief cracks, which do, however, not affect the wear resistance.

Field of use

This wire is especially suitable for repair of equipment used in mining and steel mills. Hardfacing equipment and tools used in the construction and agriculture industries, highway construction equipment, and conveyor chains, mixing paddles, cement pumps components, etc.

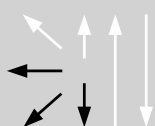
Typical analysis in %

C	Mn	Si	Cr	Ni	B	Fe
0.3	1.1	0.4	0.3	1.5	4.8	balance

Typical mechanical properties

Hardness as welded: 62-67 HRC

Welding positions



Current type: DC (+)
Shielding gas: M21 (EN ISO 14175)
Consumption: 15-18 l/min

Packaging, weights and welding parameters

Diameter [mm]	Spool	Weight [kg]	Amperage [A]	Voltage [V]
1.2	B300	16	120-250	20-31
1.4	B300	16	150-280	20-31
1.6	B300	16	180-320	25-35