

Classifications

EN 14700

DIN 8555

T Fe16

MF 10-GF-65-G

Characteristics and typical fields of application

CrNb alloy designed to resist high stress grinding abrasion at service temperature not exceeding 450 °C. The deposit will readily show stress relief cracks.

Microstructure: Austenitic matrix with primary & eutectic carbides and nodular Nb carbides

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 10 to 12 mm in 2 to 3 layers.

Field of use: Shovel, excavator, dredge and dragline bucket lips and teeth, hammers, rippers, crushing equipment, wear plates, expeller screws, giratory crushers, etc.

Typical analysis

	C	Si	Mn	Cr	Nb	Fe
wt.-%	5.3	0.8	0.2	20.4	6.7	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
u	64
u - untreated, as welded	

Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	NO GAS	1.6	180-200	26-30
	Stick-Out	35-40 mm	2.0	200-250	26-30
			2.4	250-300	26-30
			2.8	300-350	26-30

Approvals

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