

## Classifications

<b>EN 14700</b>	<b>DIN 8555</b>
T Fe6	MF 6-GF-60-GP

## Characteristics and typical fields of application

Martensitic steel alloy designed for welding in horizontal and vertical-up positions under gas shielding. Its resistance to friction and low stress abrasive wear with moderate impact is excellent.

Microstructure: Martensite  
 Machinability: Grinding only  
 Oxy-acetylene cutting: Flame cut is difficult  
 Deposit thickness: Depends upon application and procedure used


Field of use: Bucket teeth, gravel pumps, conveyor chains, sliding metal parts, gear teeth, crusher hammers, rock drills

	C	Si	Mn	Cr	Mo	Ti	Fe
wt.-%	0.47	1.1	1.5	5.8	0.9	0.1	bal.

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

Condition	Hardness
u	59
u - untreated, as welded	

## Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	M21: Argon 82% + CO2 18% C1: CO2 100%	0.9	80-170	17-30
	Stick-Out	max. 20 mm	1.2	110-180	20-31
	Gas-Rate (L/min)	0,9mm / 1,2mm: 12-15 1,6mm: 15-18	1.6	150-250	20-31

## Approvals

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