

**Standards**

TS EN 14700	: T Fe9
EN 14700	: T Fe9
DIN 8555	: - MF 7-GF-200 KP

**Chemical Composition of  
Weld Metal (Typical)**

C	Si	Mn	Cr	Fe
0.40	0.75	15.0	15.0	Rest

**Mechanical Properties**

Hardness	
(As Welded) (HRC)	(After Working) (HRC)
18 - 24	45 - 52

**Typical Base Material Grades**

- Manganese rock crushing hammers and rolls, impactor bars, gyratory mantles, dredge components

**Features and Applications**

- Applicability in buffer layer and surfacing of carbon- and manganese-steels
- High resistance to impact and friction
- Most common applications in hardfacing of various equipment parts that are exposed to deep impacts, pressure and wearing in cement, mining and earth-moving industries
- Build up depth is generally unlimited. Weld metal hardness increases by work hardening
- Shielding Gas: Open Arc

**Welding Positions**

**Operating Data**

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	25.0 - 30.0
2.80	300 - 500	25.0 - 31.0	25.0 - 30.0

**Current Type**

FCAW / D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100379	1.60	1/16	15
6031100380	2.80	7/64	25

**Approvals:** GOST-R, CE, SEPRO