

Standards

TS EN 14700	: T Fe 15
EN 14700	: T Fe 15
DIN 8555	: MF 10-GF-60 G

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

C	Si	Mn	Cr	Fe
5.0	1.5	1.3	27.0	Rest

Mechanical Properties

Hardness
(As Welded) (HRC)
60 - 64

Typical Base Material Grades

- Ventilators, wear plates, crushers for soft materials, shredders, chemical and food processing industries.

Features and Applications

- Open arc, hardfacing flux cored wire with Cr-Carbides
- It is suitable for low alloyed steel and carbon steels
- Weld metal is very hard and it is common to have transverse cracks on weld seam
- Max. two passes can be weld with this wire

Welding Positions

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	20.0 - 25.0
2.80	300 - 500	25.0 - 31.0	20.0 - 25.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100374	1.60	1/16	15
6031100186	2.80	7/64	25

Approvals: GOST-R, CE, SEPRO