

Standards

TS EN 14700	: T Z Fe 16
EN 14700	: T Z Fe 16
DIN 8555	: MF 10 GF 65 G

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

C	Mn	Si	Cr	B
~2.00	0.5	0.5	7.5	4.5

Mechanical Properties

Hardness
(As Welded) (HRC)
65 - 67

Typical Base Material Grades

- Repair of equipment used in mining and steel mills. Hardfacing equipment and tools used in the construction and agriculture industries, highway construction equipment, conveyor chains, mixing paddles, cement pumps components, etc

Features and Applications

- High-alloy metal powder flux-cored wire without slag for hardfacing preferred without shielding gas
- Use with CO₂ and Ar-CO₂ mix possible
- The weld metal characteristics and structure is similar to hard chrome alloys
- Excellent resistance to abrasion from sand and minerals
- The weld metal is machinable only by grinding
- Stringer bead technique is recommended
- The hardfacing contains check cracks, but this does not impair wear resistance

Welding Positions

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	180 - 350	25.0 - 32.0	20.0 - 25.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500026	1.60	1/16	15

Approvals: GOST-R, CE, SEPRO