

Standards

| | |
|-------------|-----------------|
| TS EN 14700 | : T Fe15 |
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| DIN 8555 | : MF 10 GF-65-G |

Chemical Composition of Weld Metal % (Typical)

| C | Si | Mn | Cr | Nb | Fe | B |
|-----|-----|-----|------|-----|------|-----|
| 5.2 | 1.3 | 0.4 | 22.0 | 7.0 | Rest | 1.0 |

Mechanical Properties

| |
|-------------------|
| Hardness |
| (As Welded) (HRC) |
| 62 - 65 |

Typical Base Material Grades

- Hardfacing of mining equipments, augers, impellers, dredgers, drills, gearwheels and parts. Fan blades, excavator scoops, bucket lips and wear plates

Features and Applications

- Extremely high hardness with specially-proportioned chemical composition including high amounts of C, Cr, Nb, B. High strength to abrasion provided by the special chemical composition
- Shielding Gas: Open Arc

Resistance Type and Level

| | | | |
|----------|--------------|------------------|-----------|
| Friction | High Temp. | Corrosive | Machining |
| ■■■■■ | ■■■■□ | ■■■■□ | ■■■■□ |
| Impact | Thermo Shock | Crack Resistance | |
| ■■■■□ | ■■■■□ | ■■■■□ | |

Operating Data

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

Current Type

FCAW / D.C. (+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Package Weight (Kg) |
|--------------|---------------------------------|------|---------------------|
| 6031100375 | 1.60 | 1/16 | 15 |

Approvals: SEPRO