

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	Ni	Fe
0.55	0.10	12.8	2.50	Rest

Mechanical Properties

Hardness	
(As Welded) (HB)	(After Working) (HB)
175- 225	~ 500

Typical Base Material Grades

- Flux cored wire contains %12Mn.
- Weld metal microstructure is austenitic therefore has excellent impact resistance

Features and Applications

- GeKaTec HARDCOR 14Mn G is used for joining and buildups of work pieces made of hard austenitic manganese steels subjected to impact and abrasion wears
- Weld deposit ensures workhardening under impact and shock because of fully austenitic structure
- Used in crusher cylinders, crusher hammers and jaws made of %12 - 14 Mn Steels
- Shielding Gas: CO₂ (M21)

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)
1.20	170 - 200	27.0 - 30.0	25.0 - 30.0
1.60	180 - 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)
3030500020	1.20	0.047"	15
3030500021	1.60	0.062"	15

Approvals: SEPRO