

Standards

TS EN 14700	: T Fe 9
EN 14700	: T Fe 9
DIN 8555	: MF 7-250 KNP

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

C	Si	Mn	Ni	Cr
1.1	0.3	14.0	0.6	4.0

Mechanical Properties

Hardness	
(As Welded) (HB)	(After Working) (HB)
170 - 200	~ 500

Typical Base Material Grades

- Flux cored wire contains % 14 Mn, weld metal microstructure is austenitic therefore has excellent impact resistance

Features and Applications

- Used in crusher, cylinders, crusher hammers and jaws etc. Made of %14 Mn steels.
- 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 - 30.0	25.0 - 30.0

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100199	1.60	0.062"	15

Approvals: SEPRO