

Standards

TS EN 14700	: T Fe1
EN 14700	: T Fe1
DIN 8555	: MF 1-GF-300 P

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

C	Si	Mn	Cr	Fe
0.13	0.30	1.00	2.0	Rest

Mechanical Properties

Hardness (as welded) (HB)
300

Typical Base Material Grades

- Steel mili rolls, shafts, steel hammers, gear teeth, shovel pads, conveyor chains, crane wheels, rail track changers, gear wheels, sprockets as well as carrying rollers

Features and Applications

- Suitable for uses in buffer-layer welding before hardfacing applications on parts exposed to high impact/pressure/wear. Alloy group is low alloy steel. Low alloy wire designed for build- up on carbon steels. Slag removal is very good. GeKaTec HARDCOR 300 G has excellent compressive strength and resistance to cracking. Machinability is very good. Requirement of cleaning of base material's surface and of heating of the base material at approximately 150°C

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	17.0 - 19.0	25.0 - 30.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500004	1.20	0.047"	15

Approvals: SEPRO