

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	2.50	1.25	Rest

Mechanical Properties

Hardness (as welded) (HB)
300

Typical Base Material Grades

- Steel mill 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 0 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. Build up is generally unlimited with proper heat treatment procedures. 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	180 - 200	26.0 - 30.0	25.0 - 30.0
2.80	300 - 500	23.0 - 31.0	25.0 - 30.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100376	1.60	1/16	15
6031100364	2.80	7/64	25

Approvals: SEPRO