

Standards

TS EN 14700	: T Fe7
EN 14700	: T Fe7
DIN 8555	: MF 5-45-PRT

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni	Mo	Nb	V	Fe
0.14	1.0	1.0	13.0	3.5	1.2	0.2	0.1	Rest

Mechanical Properties

Hardness (as welded) (HRC)
43 - 45

Typical Base Material Grades

- Casting rollers particularly at iron-steel production plants, relays, valves, valves used in gas/water/steam environments, flanges, compressors,

Features and Applications

- Suitability for use in welding of martencitic-ferritic materials used as tools for rolling, forging and steel casting operations
- Welding bead's hardness value of approximately 40 HRC, which the weld maintains at high temperatures
- High resistance to corrosion

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	150 - 250	20 - 31	20 - 25

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100369	1.60	0.062"	15

Approvals: SEPRO