

### Standards

TS EN 14700	: T Fe15
EN 14700	: T Fe15
DIN 8555	: MF 10-GF-55 G

### Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Cr	Fe
4.80	1.20	1.20	27.0	Rest

### Mechanical Properties

<b>Hardness</b>
(As Welded) (HRC)
58 - 62

### Typical Base Material Grades

- Hardfacing of bucket teeth, excavator buckets, brick pres spring, fan blades, drills, mixer and blades, grinding/pulverizing rolls and table segments, wear plates, clad pipe, dredge pump shells and related components, hammers.

### Features and Applications

- Open arc, hardfacing flux cored wire with Cr-Carbides
- Used in hardfacing welding of parts exposed to high abrasive wear
- It is common to have transverse cracks on weld seam
- Weld metal can be machined by grinding
- Max. two passes can be weld with this wire

### 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)
2.80	300 - 500	25.0 - 31.0	25.0 - 30.0

### Current Type

FCAW / D.C.(+)

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100371	2.80	7/64	25

Approvals: SEPRO