

Standards

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|-------------|------------------|
| TS EN 14700 | : T Fe8 |
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| DIN 8555 | : MF 10-GF-55-GP |

Chemical Composition of Weld Metal % (Typical)

| C | Si | Mn | Cr | Mo | Ti | Fe |
|------|-----|-----|-----|-----|-----|------|
| 1.80 | 1.5 | 2.0 | 7.0 | 1.4 | 5.0 | Rest |

Mechanical Properties

| Hardness |
|-------------------|
| (As Welded) (HRC) |
| 52 - 57 |

Typical Base Material Grades

- Roller presses, grinding/pulverizing rolls, dredge pump shells, rock crushing hammers, shredders, asphalt, kneaders, crashing hard materials, vertical shaft impact crusher rotors, roller presses.

Features and Applications

- FC wire containing C, Cr, Ti and Mo alloys
- Weld metals with martensitic microstructure including titanium carbide
- High resistance to wear and to impact
- Machinability of weld metal through grinding
- Best suited for applications involving extreme wear under high pressure
- 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 |
| 2.80 | 300 - 500 | 25.0 - 30.0 | 25.0 - 30.0 |

Current Type

FCAW / D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Package Weight (Kg) |
|--------------|---------------------------------|------|---------------------|
| 6031100372 | 1.60 | 1/16 | 15 |
| 6031100373 | 2.80 | 7/64 | 25 |

Approvals: CE, SEPRO