

Standards

TS EN 14700: T Fe 8
EN 14700 : T Fe 8
DIN 8555 : MF 6 GF 60 GP

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

Mo	V	C	Si	Mn	Cr	Fe
0.25	0.20	0.60	0.60	0.60	5.50	Balance

Mechanical Properties

Hardness (as welded) (HRC)
57-62

Features and Applications

- Metal type flux- cored wire.
- Examples of applications; cutting tools, blades of shears, rolls for cold rolling mills, roller table roll, forging die, jaw crusher, breaker hammer, beating arm, clod crusher, ripper tooth, scarifiers, mixer part, mixer bottom, blast furnace valve, top gas valve, sea dredger slide guide, shackle, mixer parts.
- Used for resistance to abrasion, impact resistance and heat resistance.
- The weld metal is air- hardening and can usually only be worked by grinding.
Preheating up to 200 to 300°C is recommended.
- Shielding Gas: CO₂ (M21)

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	27 - 30	25 - 30
1.60	180-200	26-30	30-35

Current Type

D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500406	1.20	0.047"	15
3030500408	1.60	0.062"	15