

**Standards**

DIN 8555 : MF 6-GF-60-GP

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

C	Si	Mn	Cr	Fe
0.80	1.20	1.40	8.0	Rest

**Mechanical Properties**
**Hardness (as welded)**  
 (HRC)

58

**Typical Base Material Grades**

- Hardfacing of parts of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in other materials required to have high resistance to wear, debarking knives, agricultural tillage tools, earth moving bucket lips

**Features and Applications**

- High resistance to wear and to impact. Alloy group is martensitic tool steel
- Weld metals of high hardness and high toughness
- Machinability of metal through grinding only
- It is excellent choice for components that are required to maintain a sharp edge
- 58 HRC offers high hardness with good balance between abrasion and impact resistance
- 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	20.0 - 25.0
2.80	325 - 450	26.0 - 30.0	20.0 - 25.0

**Current Type**

FCAW / D.C. (+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100377	1.60	1/16	15
6031100378	2.80	7/64	25

**Approvals:** SEPRO