

Standards

TS EN 14700	: T Fe 16
EN 14700	: T Fe 16
DIN 8555	: MF 10 GF 65 GT

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr	Nb	Mo	W	V	Fe
5.2	0.4	1.0	21.0	7.0	7.0	2.0	1.0	Rest

Mechanical Properties

Hardness

(As Welded) (HRC)

63 - 65

Typical Base Material Grades

- Clad wear plate, slurry pipe, cement furnace components, sinler plant parts, fan blades, mixer blades, screws

Features and Applications

- It is self shielded flux cored hardfacing welding wire composed of a high density of primary chromium with multiple secondary carbides
- Because of the high content of C, Cr, Mo, Nb, W, V and their hard carbides, hardness at the temperatures can be established
- Designed specifically for single and double pass applications in high temperature environments
- Weld deposit contains stress relief cracks, but this does not impair wear resistance
- Chromium-Niobium-Molybdenum alloy with addition of Tungsten and Vanadium designed to resist high stress grinding abrasion with low impact and solid erosion at service temperatures up to 650°C

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	25.0 - 30.00

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100209	1.60	1/16	15

Approvals: SEPRO