

Standards

TS EN 14700	: T Fe8
EN 14700	: T Fe8
DIN 8555	: MF 6 GF 55 GT

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

C	Si	Mn	Cr	Mo	W	V
0.65	0.50	1.55	7.20	1.00	1.60	0.10

Mechanical Properties

Hardness
(As Welded) (HRC)
53 - 56

Features and Applications

- This hardfacing flux cored wire has excellent wear resistance and keeps its strength at high temperatures
- Used in cold and hot work tool steels, hot shape knives, extrusion die and steel casting and dies
- Shielding gas: M21

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)
1.20	150 - 220	26 - 30	20 - 25

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500024	1.20	0.047"	15

Approvals: SEPRO