

Classifications

DIN 8555

MF 1-GF-350-GP

Characteristics

Rebuilding and hardfacing alloy for carbon steel parts.

Microstructure: Bainite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 82% + CO₂ 18% or CO₂ 100%

Field of use

Sliding metal parts, gear teeth, undercarriage links, rollers and idlers, shafts, bushing.

Typical analysis in %

C	Mn	Si	Cr	Mo	Fe
0,35	1,5	0,4	1,8	0,5	balance

Typical mechanical properties

Hardness as welded: 330 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18
2,0	200-325	20-31	20 max.	15-18
2,4	250-350	20-31	20 max.	18-20