

Classifications

DIN 8555 : MF 22-GF-45-G

Characteristics

Hardfacing cored wire containing about 45 % special Tungsten carbide particles incorporated in a NiB matrix. Thanks to the high degree of preservation of the Tungsten carbides in the deposit, this wire offers an outstanding resistance to abrasive wear, even when wear occurs in a corrosive environment.

Microstructure Tungsten carbides into an austenitic matrix

Machinability Grinding only

Oxy-acetylene cutting Not possible

Deposit thickness 6 mm in 2 layers maximum

Shielding gas Argon 98 % + Oxygen 2%

Metal cored

Field of use

Wheel excavator bucket teeth, brick and clay mill augers, wood chipper spout and bed knives in the paper industry and crusher rollers, dredging wear parts, etc.

Typical analysis in %

C	Mn	Si	Ni	W	B	Fe
2.80	0.1	0.1	BAL	42.0	0.70	1.1

Typical mechanical properties

Hardness as welded: 44HRc

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas Rate [kg / kg wire]
1,6	170-220	19-23	20 max	12-15