

Classifications

DIN 8555	EN 14700
MSG 10-GF-65-G	T Fe 13

Characteristics

Seamless, NiB-alloyed, metal-cored wire for hardfacing applications. The weld metal characteristics and structure is similar to hard chrome alloys. Excellent resistance to abrasion induced by sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The deposit will readily show stress relief cracks, which do, however, not affect the wear resistance.

Thanks to its constant wire feed and excellent weldability, this wire is especially suited for automated welding.

Application field

This wire is especially suitable for repair of equipment used in mining and steel mills, or hardfacing equipment and tools used in the construction and agriculture industries, highway construction equipment, conveyor chains, mixing paddles, cement pumps components, etc.

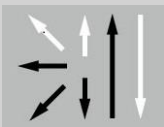
Typical analysis in %

C	Mn	Si	Cr	Ni	B
0.3	1.1	0.4	0.3	1.5	4.5

Mechanical properties

Hardness as welded: 62 – 67 HRC

Welding positions



Current type: DC (+)

Shielding gas: M21 (EN ISO 14175)
Flow rate: 15 – 18 l/min

Recommended welding parameters

Diameter [mm]	Spools	Weight [kg]	Amperage [A]	Voltage [V]
1,2	BS300	16	120 – 300	20 – 32
1.6	BS300	16	180 – 420	22 – 34
2,0	BS300	16	200 – 430	24 – 36

Other diameters on request.