

Classifications

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

Characteristics and typical fields of application

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.

Field of use: repair of equipment used in mining and steel mills, hardfacing equipment and tools used in the construction and agriculture industries, highway construction equipment, conveyor chains, mixing paddles, cement pumps components, etc

Typical analysis

	Gas	C	Si	Mn	Cr	Ni	B
wt.-%	M21	0.3	0.4	1.1	0.3	1.5	4.5

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
	Hardness
u	62 - 67
u - untreated, as welded	

Operating data

	Polarity	DC+	Dimension mm
	Shielding gas (EN ISO 14175)	M21	1.2
			1.6
			2.0

Approvals

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