

Classifications					
EN 14700		DIN 8555			
T Fe8		UP 6-GF-55-C			
Characteristics					
Alloy depositing a martensitic steel containing 13 % Chromium giving a good resistance to metal-to-metal wear and corrosion.					
Microstructure:	Martensite				
Machinability:	Good with cubic Boron Nitride tipped tools				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	Depends upon application and procedure used				
Welding flux:	Record SA				
Field of use					
Dredging pump casings, continuous casting rollers.					
Typical analysis in %					
C	Mn	Si	Cr	Fe	
0.27	1.3	0.3	13.5	balance	
Typical mechanical properties					
Hardness as welded: 53 HRC					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
2.4	275 – 450	28 – 30	30 – 35	1.1	35 – 45
3.2	325 – 500	28 – 32	30 – 35	1.1	40 – 50