



D-100Mo

Technical data sheet
las/06/20

CLASSIFICATION

DIN 8555: MF 10-60-GR

DESCRIPTION

- C, Cr, Mo alloyed wire
- High chromium cast iron for hardsurfacing components subject to extremely severe abrasive mineral wear and moderate impact and a higher temperature resistance compare to D100
- The deposit contains a high proportion of hard primary carbides and M7 C3 eutectic carbides in a tough austenitic matrix
- The deposits will stress relief readily
- Very clean weld deposits and the deposits are not machinable
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TYPICAL APPLICATIONS

Palm oil expeller screws, wear plates, dredge pump impellers, gyratory crusher cones and mantles, slurry pipes, sand dredge parts, "barmac" crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, sugar mill crusher hammers, drag line components, coal pulverising rolls and tables, hammers, shredders.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
5.06	0.92	1.08	29.9	1.1

TYPICAL HARDNESS

Hardness – 3-layer deposit on mild steel: 60 – 62 HRc

CONDITIONS OF USE

Current type	Protection
DC (+)	Self shielded

WELDING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 250	200	24 - 33	28	25 – 35	25
1.6	150 - 300	240	26 - 33	28	25 – 35	25
2.0	200 - 350	280	26 - 33	28	25 – 35	25
2.4	250 - 450	350	26 - 33	28	25 – 35	25
2.8	250 - 450	400	28 - 33	30	25 – 35	30
3.2	300 - 500	450	28 - 33	30	25 - 35	30

Recovery: > 90%

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4, 2.8,3.2

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	BS 300	Coil	POP
Weight	15 kg	25 kg	125 and 250 kg

Other packaging: please consult us