

CARBOLOY 520

International standards	DIN 855	5	I	E 23-UN	l-300-CK	NPTZ					
Approvals											
Typical applications and characteristics	CARBOLOY 520 is a lime basic coated high CrCoMoTiAIW alloyed nickel based electrode. The deposit is a precipitation hardenable alloy with an exceptional combi- nation of high temperature mechanical property capabilities, forgeability and corrosion resistance. The alloy can be used for a great number of critical high temperature applications.										
Operating temperature											
Welding instructions	To achieve a crack-free overlay, the base material should be preheated to 300 – 400°C, depending on the alloy. Slow cooling after welding is advised.										
		oning and		y is advi	seu.						
Hardness of all-weld metal			welded		HR	c worl	k-harden	ned			
Hardness of all-weld metal (typical values)			welded			c wor l ca.		ed			
all-weld metal		IB as	welded	Mo				ned]		
all-weld metal (typical values)	F	IB as	welded		HR	ca.	39]		
all-weld metal (typical values) Weld metal analysis	C	IB as ca. : Cr	welded 300 Co	Mo	HRo	ca.	39 W	Ni			
all-weld metal (typical values) Weld metal analysis (typical, wt. %)	C 0,04	IB as ca. 3 Cr 19	welded 300 Co 12	Mo	HRo	ca.	39 W	Ni			
all-weld metal (typical values) Weld metal analysis (typical, wt. %) Current	C 0,04 = + PA, PB,	IB as ca. 3 Cr 19	welded 300 <u>Co</u> 12 , PE, PF	Mo 5,5	HRo	ca.	39 W	Ni			

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
3,2 x 350	80 - 120	155	619	32,3	5,0	20,0
4,0 x 350	110 - 150	102	409	48,9	5,0	20,0
5,0 x 450	150 - 190	61	244	98,2	6,0	24,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.