

CARBO S-G 600 CARBO T-G 600

International standards				S = s	olid wir	е	T =	bare ro	bd	
		Mat. No.			1.471	1.4718				
		DIN 8555		MSG 6-GZ-60-S		V	WSG 6-GZ		-60-S	
Application no	Solid wire for rebuilding of machine parts subject to combined wear from abrasion and impact. Suitable for deposits on mild steel, steel castings and manganese steel. The pure weld deposit is only machinable by grinding. On high-carbon and crack-sensitive base materials, should be preheated to 200° – 300° C, depending on their composition and thickness.									
Hardness of all-weld metal (typical values)		mining and earth-moving eq as welded soft annealed 5 h			d	uipment Hardened oil - air cooling				
		59 HRc	780	780°C – 820°		1000°C – 1050°C				
Weld metal analysis (typical, wt %)		0,5 3	Si 3,0	Mn 0,5 blid wire	Cr 9		T:	= bare I	rod	
Gas types EN 439				M3, C1			I1			
Current				= +	4.0	4.0		= -		4.0
Diameter	mm	0,8	1,0	1,2 180	1,6 250	1,6	2,0	2,4	3,2	4,0
Welding amps	(A) min. (A) max.	80 130	120 190	250	250 320					
coils, weight Rev. 001/13		B300 15	kg.		10 kg.					

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.