

CARBO S-1.2343 CARBO T-1.2343

International standards				S =	solid wir	е		T = bare	rod	_,
		Mat. No. 1.2343								
Typical applications and characteristics		CARBO T+S 1.2343 for high wear resistant hardfacings on hot- and cold- working tools. The deposit has a crack-free Cr-Mn- martensitic structure. Particularly recommended for hardfacing hot- and cold-working trimming dies, pressing- and blanking dies, hot- and cold-shear- blades like hot-billet-shears, blanking-,punching and coining tools, rotary-shear-knives, hot- and cold-forming- and drawing-dies.								
Recommendations for welding and heat treatment		For achieving optimal crack-free deposits preheating of the base material to 250-350 centigrade is essential. Short runs are desirable using the step back technique.								
Base materials 1.2343 X380 1.2344 X400 1.2082 X210			X38CrM X40CrM X21Cr13	IoV5-11.2083 X42Cr13IoV5-11.2367 X38CrMoV5-331.2606 X37CrMoW5-1						
Mechanical properties of all-weld metal		First HF	layer C							
(typical values)		52-	57							
Weld metal analysis (typical, wt %)		C 0,38	Si 1,0	Mn 0,4	Cr 5,0	Mo 1,1	V 0,45	Fe Base		
Gas types EN 439		S = solid wire				T = bare rod				
		M2, M3						11		
Current			:	= +			= -			
Diameter	mm	0,8	1,0	1,2	1,6	1,	62	,0 2,4	3,2	4,0
vvelding amps	(A) min.	80 130	120	180 250	250 320					
	(n) max.	130	190	200	520					
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.