

## **CARBO S-1.2713 CARBO T-1.2713**

## International standards

	S = solid wire	T = bare rod
Mat. No.	1.271	3

## Typical applications and characteristics

CARBO T+S 1.2713 for high wear resistant hardfacings on hotand cold- working tools. The deposit has a crack-free Cr-Ni-Mo-Mn- martensitic structure. With low carbon content. Particularly recommended for hardfacing hot- and cold-working trimming dies, pressing- and blanking dies, hot- and cold-shearblades 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** 

1.2713	55NiCrMoV6	1.2747	28NiMo17
1.2714	56NiCrMoV7	1.2764	X19NiCrMo4
1.2740	28NiCrMoV10	1.2766	35NiCrMo16
1.2743	60NiCrMoV12-4	1.2767	X45NiCrMo4
1.2744	57NiCrMoV7-7		

Mechanical properties of all-weld metal

(typical values)

First layer HB
ca. 360-420 HB

Weld metal analysis (typical, wt %)

Rev. 001/13

С	Si	Mn	Cr	Ni	Мо	V	Fe
0,25	0,30	0,5	1,45	3,60	0,40	0,2	Base

Gas types EN 439		S = solid wire M2, C1				T = bare rod				
<b>Current</b> Diameter	mm	8,0	= 1,0	+ 1,2	1,6	1,6	2,0	= <b>-</b> 2,4	3,2	4,0
Welding amps		80 130	120 190	180 250	250 320	1,0	2,0	<b>4</b> , <b>T</b>	0,2	7,0
coils, weight	(1.4) 1112211		5 kg.		0_0	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.