CARBO WELD
SCHWEISSMATERIALIEN GMBH

# CARBO F-250

**Standards**

| | |
|---|---|
| DIN 8555 | MF7-GF-250-KNP |

**Characteristics**

CARBO F-250 is a Mn-, Cr- alloyed tubular wire. The fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits are work hardening up to 500 HB, stainless and not magnetic. CARBO F-250 is suitable for welding buffer layers before welding over old hardfacings, because it deposits a ductile weld metal. The deposit resist high shrinkage stresses and impact loading.

**Typical applications**

Repair of: manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels

**Mechanical properties of all-weld metal**

(typical values)

| Hardness HB | Hardness after work hardening HB |
|---|---|
| 200- 250 | approx. 500 |

**Weld metal analysis** (typical, wt. %)

| C | Si | Mn | Cr | Ni | Mo | V |
|---|---|---|---|---|---|---|
| 0,4 | 0,4 | 16,0 | 14,0 | 1,2 | 0,6 | 0,2 |

**Gas types EN 439**

I1, M13: Argon and 99% Argon for 1% Oxygen

**Current**

= +

**Current intensity**

| DIA (mm) | DIA (inch) | Volt | Amps | Delivering form | | |
|---|---|---|---|---|---|---|
| 1,2 | 3/64 | | | | | |
| 1,6 | 1/16 | 20 - 26 | 160 - 260 | **O** | **G** | |
| 2,0 | 5/64 | 22 - 27 | 220 - 280 | **O** | **G** | |
| 2,4 | 3/32 | 24 - 28 | 260 - 340 | **O** | **G** | |
| 2,8 | 7/64 | 25 - 29 | 300 - 400 | **O** | | **S** |
| 3,2 | 1/ 8 | 26 - 30 | 320 - 460 | **O** | | **S** |

**Delivering form**

**O** = Flux cored wire self shielding
**G** = Flux cored wire for shielded arc welding
**S** = Flux cored wire for submerged arc welding

**Coils, weight**

B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150/300 kg

Rev. 000