

Standards

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| DIN 8555 | MF6-GF-55-PT |
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Characteristics

CARBO F-602 is a tubular wire which gives a Cr-, Mo-, V- alloyed weld deposit with excellent properties of resistance to abrasion and impact.

The deposit is crack-free, hard and tough. For base materials that are difficult to weld, a buffer layer of 250K or preheating is recommended. Applications are crusher wheels, dredger parts, pan grinders, and as the final layer for hardfacing manganese steel.

The weld metal is very crack resistant and extremely tolerant in this respect to poor preheat and interpass temperature conditions. The deposit is resistant to erosion and moderate abrasion.

The number of layers can be done as necessary.

The deposit can be additionally treated with cutting tools.

Typical applications

dredging parts, gravel pumps, blow bars, screws, crusher hammers, drive tumblers

Mechanical properties of all-weld metal
(typical values)

| |
|---------------------|
| Hardness HRC |
| 55-57 |

Weld metal analysis
(typical, wt. %)

| C | Si | Mn | Cr | Mo | V |
|-----|-----|-----|-----|-----|-----|
| 0,5 | 1,0 | 3,0 | 6,5 | 0,8 | 0,4 |

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 | 19 - 22 | 120 - 220 | O | G |
| 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

Coiling / Weight

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

Rev. 000