

Standards

DIN 8555	MF 10-60-GR
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Characteristics CARBO F- 56 is a tubular wire which deposits a high Cr-, C- Mo alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever high abrasion is expected. Compared with CARBO F-55, the weld deposit of this electrode has a higher temperature resistance (up to 450°C). Best results are achieved by welding in two layers. A maximum deposit thickness of 10 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications Pumps, mixer parts, conveyer screws

Working temperature

Hardness of pure weld metal

as welded (HRc)
approx. 59

Weld metal analysis (typical, wt. %)

C	Si	Cr	Mo				
5,0	1,5	27	1,3				

Gas types EN 439 **M 13**

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

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

Rev. 000