

CARBO F- 59

Standards	DIN 8555		MF 10-60-GF	2			
Characteristics	CARBO F- 59 is a tubular wire which deposits a high chrome carbide alloyed weld metal with excellent resistance to abrasion and moderate impact. It can be used whenever high abrasion is expected. 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 on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.						
Typical applications	Pumps, impeller screws, track hoppers						
Hardness of pure weld metal	as welded (HRc) 59 - 60						
Weld metal analysis (typical, wt. %)	C Si 5,0 1,2	Cr 32	B +				
Gas types EN 439	M 13						
Current	= +						
Current intensity	DIA (mm) 1,2 1,6 2,0 2,4 2,8 3,2	DIA (inch 3/64 1/16 5/64 3/32 7/64 1 / 8	Volt 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30	260 - 3	220 260 C 280 C 340 C 400 C) G) G)	form S 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		B 450 = 30 kg	pay off pack = 150 / 300 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.