

Standards

DIN 8555	MF 10-GF-60-GR
----------	----------------

Characteristics

CARBO F- 10 is a tubular wire which deposits a high Cr-, C-, Nb- alloyed weld metal with excellent resistance to abrasion and medium 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, mixer parts, conveyer screws

Hardness of pure weld metal

as welded (HRc)
60 - 63

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Nb	Fe
5	1	1	22	2	Base

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		
1,6	1/16	20 - 26	160 - 260	O	
2,0	5/64	22 - 27	220 - 280	O	
2,4	3/32	24 - 28	260 - 340	O	S
2,8	7/64	25 - 29	300 - 400	O	S
3,2	1 / 8	26 - 30	320 - 460		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