

CARBO F- 50

Standards DIN 8555 MF10-GF-50-G

Characteristics C-, Cr-, Si-, Mn- alloyed flux cored wire on parts which subjected to

abrasive wear and medium impact

Typical applications Abrasive wear in combination with medium impact

Working temperature

Hardness of pure deposits

as welded (HRc)	
Ca. 52	

Weld metal analysis

(typical, wt. %)

С	Si	Mn	Cr
3,0	1,8	1,8	15,0

Gas types EN 439 --

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering f	orm
1,2	3/64	19 - 22	120 - 220	0	
1,6	1/16	20 - 26	160 - 260	0	
2,0	5/64	22 - 27	220 - 280	0	
2,4	3/32	24 - 28	260 - 340	0	
2,8	7/64	25 - 29	300 - 400	0	S
3,2	1 / 8	26 - 30	320 - 460	0	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

Than colou mile for cusmorged are meranig

Coils, weight

B/BS 300 = 15 kg

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.