CARBO F- 65

Standards

DIN 8555	MF10-GF-65-GZ

Characteristics

High C-, Cr-, Mo-, Nb-, V-, W-alloyed flux-cored self shielding wire which forms extremely hard carbides. This is used for hardfacing against extremely strong mineral wear. The deposit retains its wear resistance up to 650°C. At 400°C the hardness decreases about 4 %, at 650°C about 10 %.
Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications

Blast-furnace bells, fire grates, crusher

Mechanical properties of all-weld metal (typical values)

Hardness HRC 20 °C	Hardness HRC at 400 °C	Hardness HRC at 650 °C
approx. 64	approx. 61	approx. 57

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo	Nb	V	W
5,2	1,0	0,20	21,0	7,0	7,0	1,0	2,0

Gas types EN 439

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**	**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