CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO F- 67

Standards

DIN 8555	MF 10 - 65 - GZ

Characteristics

High C-, Cr-, V - alloyed flux-cored wire electrode for extreme abrasive wear even at elevated temperatures. The fine grain structure of the weld deposit prevents a washout of the matrix and therefore the deposit has an extreme high scratch hardness.

Typical applications

Cement and concrete pumps, slurry pumps

Hardness of pure deposits

as welded (HRc)
64 – 67

Weld metal analysis (typical, wt. %)

C	Si	Cr	V
5,0	1,0	22	10

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**	
2,0	5/64	22 - 27	220 - 280	**O**	
2,4	3/32	24 - 28	260 - 340	**O**	
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