

CARBO F- 354

Standards DIN 8555 MF1-GF-40-P

Characteristics CARBO F-354 is a tubular wire which produces a machinable,

tough high density deposit of about 400 HB.

The deposits are resistant to thermal shock and wear

Typical applications Repair of hammer dies, insert dies, press forging dies, where

machinable deposits are required.

Procedure The number of layers can be done as necessary. The interpass

temperature should be maximum 250°C.

In normal cases preheating is not necessary but should be

chosen according to the base material.

Hardness as welded (typical values)

HRc					
	38 - 40				

Weld metal analysis (typical, wt. %)

С	Si	Mn	Cr	Мо	W	V
0,1	0,5	1	4,5	1,5	2	0,25

Gas types EN 439 I1, M13: Argon and 99% Argon for 1% Oxygen

Current = +

Current intensity DIA (mm) DIA (inch) Volt **Amps** Delivering form 3/64 19 - 22 120 - 220 G 1,2 0 1,6 20 - 26160 - 260 0 G 1/16 22 - 27 G 2,0 5/64 220 - 280 0

2,4 3/32 24 - 28 260 - 340 0 G 2,8 7/64 25 - 29 300 - 400 0 S 1/8 26 - 30 320 - 460 S 3.2

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

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.