

**Standards**

|          |              |
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| DIN 8555 | MF1-GF-55-PT |
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**Characteristics**              CARBO F-507 is a tubular wire which produces a hot working tool steel alloy designed for tough hot and cold work tools, because the alloy has good wear resistance even at elevated temperatures.

**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.  
The deposit can be heat treated according to oil hardening heat treatment procedures.

**Typical applications**        Impactor dies, (screw) press dies, forming dies, blanking dies, etc.

**Hardness**

| as welded | Tempered at 600°C | Tempered at 590°C | Tempered at 575°C |
|-----------|-------------------|-------------------|-------------------|
| 56-58 HRc | 49-51 HRc         | 53-55 HRc         | 55-57 HRc         |

(typical values)

**Weld metal analysis**  
(typical, wt. %)

| C    | Si  | Mn  | Cr  | Mo | W   | V   |
|------|-----|-----|-----|----|-----|-----|
| 0,35 | 0,4 | 0,4 | 5,3 | 2  | 2,5 | 0,4 |

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

**Current**                            = +

**Current intensity**

| DIA (mm) | DIA (inch) | Volt    | Amps      | Delivering form |   |
|----------|------------|---------|-----------|-----------------|---|
| 1,2      | 3/64       | 19 - 22 | 120 - 220 | O               | G |
| 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 |                 | 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