

CARBO F- 812

Standards	DIN 8555	Ν	//F1-GF-45-	PT	
Characteristics	CARBO F-812 is a flux cored wire electrode, which produces a highly heat and thermal shock resistant deposit, which is machinable. The electrode is designed for maintenance of hot working tools, especially drop forge dies and to increase their service life.				
Procedure	The number of layers can be done as necessary. The interpass temperature should be maximum 250°C. Preheating should be chosen according to the base material.				
Typical applications	Impactor dies, (screw) press dies, hot forging dies, blanking dies, etc.				
Mechanical propertie		Hardness		ile strengt	h
of all-weld metal (typical values)				m N/mm²	
(typical values)	38-44 1200-1400				
Weld metal analysis	C	Si Mn	Cr	Ni Mo	V Ti
(typical, wt. %)	0,10	0,5 0,6	10	1 2	0,25 0,2
Gas types EN 439 I1, M 12, M13:					
Current					
Current	= +				
	-	DIA (inch)	Volt	Amp	s Delivering form
Current intensity	= + DIA (mm) 1,2	DIA (inch) 3/64	Volt 19 - 22	Amp 120 - 2	
	DIA (mm)	• •			20 G
	DIA (mm) 1,2	3/64 1/16 5/64	19 - 22	120 - 2 160 - 2	20 G 60 G
	DIA (mm) 1,2 1,6 2,0 2,4	3/64 1/16 5/64 3/32	19 - 22 20 - 26 22 - 27 24 - 28	120 - 2 160 - 2 220 - 2 260 - 3	20 G 60 G 80 G 40 G
	DIA (mm) 1,2 1,6 2,0 2,4 2,8	3/64 1/16 5/64 3/32 7/64	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	120 - 2 160 - 2 220 - 2 260 - 3 300 - 4	20 G 60 G 80 G 40 G 00 G
	DIA (mm) 1,2 1,6 2,0 2,4	3/64 1/16 5/64 3/32	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	120 - 2 160 - 2 220 - 2 260 - 3 300 - 4	20 G 60 G 80 G 40 G 00 G
	DIA (mm) 1,2 1,6 2,0 2,4 2,8	3/64 1/16 5/64 3/32 7/64 1 / 8 pred wire se	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30 elf shielding r shielded	120 - 2 160 - 2 220 - 2 260 - 3 300 - 4 320 - 4 3 20 - 4	20 G 60 G 80 G 40 G 00 G 60

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.