

CARBO F- 814

Standards	DIN 8555	MF	1-GF-45-PT		
Characteristics	CARBO F-814 is a flux cored wire electrode, which produces a highly heat and thermal shock resistant deposit. 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	s Ha	rdness	Tensile	strength	
of all-weld metal		HRc		N/mm²	
(typical values)	44	44-48,5		-1600	
Weld metal analysis	С	Si Mn	Cr Ni	Мо	Ti
(typical, wt. %)	0,15	0,6 0,6	10 1,7	3	0,2
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	139 I1, M 12, M13:				
Gas types EN 439	I1, M 12, M	13:			
Gas types EN 439 Current	I1, M 12, M = +	13:			
Current	= +		Volt	Amps	Delivering form
	= + DIA (mm)	13: DIA (inch) 3/64	Volt 19 - 22	Amps 120 - 220	Delivering form
Current	= +	DIA (inch)) G
Current	= + DIA (mm) 1,2	DIA (inch) 3/64	19 - 22	120 - 220) G
Current	= + DIA (mm) 1,2 1,6	DIA (inch) 3/64 1/16	19 - 22 20 - 26	120 - 220 160 - 260) G) G) G
Current	= + DIA (mm) 1,2 1,6 2,0 2,4 2,8	DIA (inch) 3/64 1/16 5/64 3/32 7/64	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	120 - 220 160 - 260 220 - 280 260 - 340 300 - 400	G G G G G G G G G G G G G G G G G G
Current	= + DIA (mm) 1,2 1,6 2,0 2,4 2,8	DIA (inch) 3/64 1/16 5/64 3/32	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	120 - 220 160 - 260 220 - 280 260 - 340 300 - 400	G G G G G G G G G G G G G G G G G G
Current	= + DIA (mm) 1,2 1,6 2,0 2,4 2,8 3,2 O = Flux co G = Flux co	DIA (inch) 3/64 1/16 5/64 3/32 7/64	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30 shielding shielded arc	120 - 220 160 - 260 220 - 280 260 - 340 300 - 400 320 - 460 : welding) G) G) G) G

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.