

CARBO F- Wz 6356

Standards	Werkstoff No.		1.6356				
	DIN 8555		E4-UM-350-CKPSTZ				
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Characteristics	Tubular wire electrode for hardfacing and repair of die stee						
	Specifically huge volume pressing tools with particular reference to						
	H 13 and mar aging steels. The deposits are easy machinable and						
	heat treatable where improved hardness is required.						
Typical applications	tions Facing of dies, stamping tools, metal drawing tools, pressure casting tools. The resultant weld metal deposits give improved edge hardness						
	cold cutting tools and snears.						
Working tomporature	20° C up to 45°	0° C					
	20 C up to 45						
Hardness of	soft annealed / 4 h at				at		
all-weld metal	as welded	480°C	480°C				
(typical values)	ca. 350		 ca. 55 HRc				
Weld metal analysis	C Si	Ni	Мо	Со	Ti]	
(typical, wt. %)	0,03 0,3	18	4	12	+		
						-	
Gas types EN 439	M13: 99% Argon with 1% Oxygen Current = +						
					-		
Current intensity	DIA (mm) D	IA (inch) Vo	t	Amp	S	Delivering form
	1,2	3/64	19 -	22	120 - 2	20	G
	1,6	1/16	20 -	26	160 - 2	60	G
	2,0	5/64	22 -	27	220 - 2	80	G
		0/04		~~			•
	2,4	3/32	24 -	28	260 - 3	40	G
	2,4 2,8	3/32 7/64	24 -	28	260 - 3	40	G
	2,4 2,8 3,2	3/32 7/64 1 / 8	24 -	28	260 - 3	40	G
Delivering form	2,4 2,8 3,2	3/32 7/64 1 / 8	24 -	28	260 - 3	40	G
Delivering form	2,4 2,8 3,2 O = Flux corec G = Flux corec	3/32 7/64 1 / 8 d wire s	24 - elf shield	28 ling	260 - 3	40 a	G
Delivering form	2,4 2,8 3,2 O = Flux corec G = Flux corec S = Flux corec	3/32 7/64 1 / 8 d wire s d wire fo	24 - elf shield or shielder subme	28 ling ed arc rged a	260 - 3 weldin	40 g	G
Delivering form	2,4 2,8 3,2 O = Flux corec G = Flux corec S = Flux corec	3/32 7/64 1 / 8 d wire s d wire fo d wire fo	24 - elf shield or shielde or subme	28 ling ed arc rged a	260 - 3 weldin	40 g Jing	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.