

CARBO F-S 1



DIN EN 14700

T Co 2-55-CGTZ

ASME IIC SFA 5.21 / AWS A 5.21 R CoCr-C

General characteristics

CARBO F-S 1 is a tubular wire which deposits a cobalt base alloy of austenitic-ledeburitic structure with embedded CrW carbides. It is the hardest of the standard Cobalt base alloys. The weld metal is highly resistant to corrosion, impact, abrasive wear as well as thermal shocks and heavy mechanical impact. The deposits are only machinable by grinding.

Working temperature from room temperature up to +1000°C

Typical applications

Due to its above-mentioned characteristics CARBO F-S 1 is particularly recommended for use on wear pads, rotary seal rings, pump sleeves, centre less grinder work rests.

Weld metal analysis (typical, wt %)

	C	Si	Mn	Cr	Co	W	Fe			
Gew-%	2,4	0,7	0,4	30,0	Basis	11,0	<3,0			

Mechanical properties of all-weld metal (typical values)

Meltingrange:	1250°C	Hardness at Rt.	ca. 55 HRc
Density g/cm ³ :	8,7	Hardness at +600°C	ca. 44 HRc
		Hardness at +800°C	ca. 34 HRc

Operating data

Current: =+

Gas typs EN ISO 14175: M13: 99% Argon with 1% Oxygen

Dia (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	16 - 23	80 - 220	G *
1,6	1/16	18 - 27	100 - 260	G *
2,0	4/64	19 - 28	120 - 320	G *
2,4	3/32	19 - 29	160 - 380	G *
2,8	7/64	20 - 30	180 - 400	S *

Delivering form

0 * = gasless (open arc), G * = gas shielded, S * = Submerged Arc

Coil "BS 300" = 15 kg

Coil "BS 450" = 25 kg

Drums = 300 kg

Statements on composition and application are just for the appliers 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.