

CARBO F-S 306

Standards	DIN 8555	MF 20-GF-35	-CTZ	
Characteristics Typical applications	CARBO F-S 306 deposits a cobalt-based alloy with an austenitic, ledeburitic structure, bearing Cr- + Nb- + W-carbides. The alloy has a high mechanical loading capacity. Apart from strong corrosion, abrasion and impact load it also withstands extreme temperature changes as well as metal-to-metal friction. Due to its high ductility the weld deposit is machinable with hard metal tools. The alloy can be applied crack-free. Hot forging tools, hot galvanizing tools, high temperature fluid			
	pumps, hot shearing	knives, hot pres	ssing dies, st	eam valves.
Working temperature	From room temperat	ure up to + 800	°C	
Hardness of all-weld metal (typical values)	HRc HB 20 ° C 200 ° 36 - 38 280	C 400 ° C	HB 600 ° C 180	HB 800 ° C 110
Weld metal analysis	C Si Mn	Cr Ni	Mo Co	Nb W Fe
(typical, wt. %)	0,6 1,3 1	25 5,5	0,5 Base	7 2,7 < 5
(typical, wt. %) Gas types EN 439	0,6 1,3 1 M13: 99% Argon v			7 2,7 <5
	I <u></u> II			7 2,7 <5
Gas types EN 439	M13: 99% Argon v	vith 1% Oxyger		7 2,7 < 5 Delivering form
Gas types EN 439 Current	M13: 99% Argon v = +	vith 1% Oxyger	1	
Gas types EN 439 Current	M13: 99% Argon v = + DIA (mm) DIA (inc	vith 1% Oxyger ch) Volt 16 – 23	Amps	
Gas types EN 439 Current	M13: 99% Argon v = + DIA (mm) DIA (inc 1,2 3/64	vith 1% Oxyger ch) Volt 16 – 23 18 – 27	Amps 80 - 200	
Gas types EN 439 Current	M13: 99% Argon v = + DIA (mm) DIA (inc 1,2 3/64 1,6 1/16	vith 1% Oxyger ch) Volt 16 – 23 18 – 27 19 – 28	Amps 80 - 200 100 - 260	Delivering form
Gas types EN 439 Current	M13: 99% Argon v = + DIA (mm) DIA (inc 1,2 3/64 1,6 1/16 2,0 5/64	vith 1% Oxyger ch) Volt 16 – 23 18 – 27 19 – 28	Amps 80 - 200 100 - 260 120 - 320	Delivering form G
Gas types EN 439 Current	M13: 99% Argon v = + DIA (mm) DIA (ind 1,2 3/64 1,6 1/16 2,0 5/64 2,4 3/32	vith 1% Oxyger ch) Volt 16 – 23 18 – 27 19 – 28 19 – 29 20 - 30 self shielding for shielded a	Amps 80 - 200 100 - 260 120 - 320 160 - 380 180 - 400	Delivering form G G S

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.