

## CARBO F-Ni Co

Standards	Material No. DIN 8555		2.4883 MF 23-GF-250-CKNPTZ							
	AWS A5.11 E NiCrMo 5									
Characteristics	High alloyed nickel based tubular wire. The CARBO F-Ni Co type deposit has outstanding physical characteristics and is resistant to both, oxidation and reduction corrosion. It work hardens under impact and by machining to ca.400 HB – even at high temperatures – without deforming the deposit. Thick layers should be buffered with CARBO F-4337. CARBO F-Ni Co is used in general for surfacing of all work-pieces subject to mechanical stress combined with corrosion and/or to high temperatures (from 400 – 750°C)									
Operating temperature	Rt. up to +400° C									
Base materials	Main applicatio shear blades, p etc.	ns: Surfa ounches,	cing of h swages,	not worki dies, pr	ng tool ess too	s as hot Is, millin	forgin Ig rolls	ng dies, s and va	hot Ilves,	
Welding instructions	To achieve a crack-free overlay, the base material should be preheated to 300 – 400°C, depending on the alloy.									
Mechanical properties of all-weld metal	Tensile strength R., N/mm <sup>2</sup>	Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>		Elongation $A_5$ %		Hardness HB		Hard H workha	Iness IB ardened	
of all-weld metal	• • m • • • • • • • • • • • • • • • • •									
of all-weld metal ( typical values)	680	50	00	>1	0	ca. 22	20	ca.	420	
of all-weld metal ( typical values) Weld metal analysis (typical, wt. %)	680       C     Cr       0,08     16	50 <b>Mo</b> 16	00 W 4,5	>1 V 0,35	0 <b>Co</b> 2,5	ca. 22	20 B	ca. Ni ase	420	
of all-weld metal ( typical values) Weld metal analysis (typical, wt. %) Gas types EN 439	680 <b>C Cr</b> 0,08 16 I1, Argon	50 <b>Mo</b> 16	00 W 4,5	>1 <b>V</b> 0,35	0 <b>Co</b> 2,5	ca. 22	20 B	ca. Ni ase	420	
of all-weld metal ( typical values) Weld metal analysis (typical, wt. %) Gas types EN 439 Current	680 C Cr 0,08 16 11, Argon = +	50 <b>Mo</b> 16	00 <b>W</b> 4,5	>1 V 0,35	0 <b>Co</b> 2,5	ca. 22	20 B	ca. Ni ase	420	
of all-weld metal ( typical values) Weld metal analysis (typical, wt. %) Gas types EN 439 Current Current intensity	680 C Cr 0,08 16 11, Argon = + DIA (mm) D	50 Mo 16	00 W 4,5	>1 V 0,35	0 <b>Co</b> 2,5 <b>Am</b>	ca. 22	20 B	ca. Ni ase	420 form	
of all-weld metal ( typical values) Weld metal analysis (typical, wt. %) Gas types EN 439 Current Current intensity	C Cr   0,08 16   11, Argon   = +   DIA (mm) D   1,2 1,6   2,0 2,4   2,8 2	50 Mo 16 16 <u>IA (inch</u> 3/64 1/16 5/64 3/32 7/64	00 <b>W</b> 4,5 19 20 22 24 25 20	>1 V 0,35 /olt - 22 - 26 - 27 - 28 - 29 - 29	0 <b>Co</b> 2,5 <b>Am</b> 120 - 160 - 220 - 260 - 300 -	ca. 22 Fe 5 220 260 280 340 400	20 B Deli	ca. Ni ase vering G G G	420 form	

Coils, weight

B/BS 300 = 15 kg B 450 = 30 kg

pay off pack = 150 / 300 kg

Rev. 000 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.