

CARBO F-NiCrB 58

Standards	DIN 8555	Ν	MF 22-60-CG	TZ	
Characteristics	Ni-, Si-, Cr-, B-alloy. which leaves a nickel-base weld deposit. The essential characteristics correspond to the Cobalt-base alloys, especially the hardness, corrosion resistance, heat resistance, wear resistance and thermal shock constancy. Applications are found in the chemical industry, nuclear technology field, etc.				
Typical applications	Fittings, chemical industry, food industry, nuclear technology, extrusion screws				
Hardness of pure	as welded (HRc)				
deposits					
acposits	55 - 60				
Weld metal analysis	C Si	Cr	Ni B	Fe	
(typical, wt. %)	0,75 4,2	13,5 E	Base 3,0	<5	
Gas types EN 439	I1, M13: 98	– 99 % Ar	gon with 1 –	2 % Oxyg	en
Gas types EN 439 Current	I1, M13: 98 = +	– 99 % Ar	gon with 1 –	2 % Oxyg	en
Current	= +		-		
	= + DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
Current	= + DIA (mm) 1,2	DIA (inch) 3/64	Volt 19 - 22	Amps 120 - 22	Delivering form
Current	= + DIA (mm) 1,2 1,6	DIA (inch) 3/64 1/16	Volt 19 - 22 20 - 26	Amps 120 - 22 160 - 26	Delivering form
Current	= + DIA (mm) 1,2 1,6 2,0	DIA (inch) 3/64 1/16 5/64	Volt 19 - 22 20 - 26 22 - 27	Amps 120 - 22 160 - 26 220 - 28	Delivering form 0 0 G 0 G
Current	= + DIA (mm) 1,2 1,6 2,0 2,4	DIA (inch) 3/64 1/16 5/64 3/32	Volt 19 - 22 20 - 26 22 - 27 24 - 28	Amps 120 - 22 160 - 26 220 - 28 260 - 34	Delivering form 0 0 G 0 G 0 G 0 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	Volt 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	Amps 120 - 22 160 - 26 220 - 28 260 - 34 300 - 40	Delivering form D O G G O G O G O O G O O
Current	= + DIA (mm) 1,2 1,6 2,0 2,4	DIA (inch) 3/64 1/16 5/64 3/32	Volt 19 - 22 20 - 26 22 - 27 24 - 28	Amps 120 - 22 160 - 26 220 - 28 260 - 34	Delivering form D O G G O G O G O O G O O
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 1 / 8 red wire se red wire fo	Volt 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30	Amps 120 - 22 160 - 26 220 - 28 260 - 34 300 - 40 320 - 46	Delivering form 0 0 0 0 0 0 0 0

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.