CARBO F-NiCrB 50

Standards	DIN 8555	MF 22-50-CGTZ

Characteristics

Fluxed core wire which leaves a tough NiCrSiB 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.

Recommendations for best welding results

Thoroughly clean the welding zone. It should be exempt from grease, scale, corrosion, and similar contamination.
Working temperature should be chosen depending on the work piece to 400 - 600° C. and has to be held during the welding process. Slowly cool down.
Subsequent heat treatment (stress relief at 700°C approx.) is not necessary, except on large structures.

Typical applications

Fittings, chemical industry, food industry, nuclear technology, extrusion screws

Hardness of pure deposits

as welded (HRc)
48 – 50

Weld metal analysis (typical, wt. %)

C	Si	Cr	Ni	B	Fe
0,45	4,2	21	Base	2,8	<5

Gas types EN 439 **I1, M13: 98 – 99 % Argon with 1 – 2 % Oxygen**

Current **= +**

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 220	
1,6	1/16	20 - 26	160 - 260	**G**
2,0	5/64	22 - 27	220 - 280	**G**
2,4	3/32	24 - 28	260 - 340	**G**
2,8	7/64	25 - 29	300 - 400	
3,2	1 / 8	26 - 30	320 - 460	

Delivering form

O = **Flux cored wire self shielding**
G = **Flux cored wire for shielded arc welding**
S = **Flux cored wire for submerged arc welding**

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000