

**Standards**

DIN 8555	MF 10-60-GR
----------	-------------

**Characteristics** CARBO F- 55 is a tubular wire which deposits a high Cr-, C- alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever high abrasion is expected. Best results are achieved by welding in two layers. A maximum deposit thickness of 10 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

**Typical applications** Pumps, mixer parts, conveyer screws

**Working temperature**

**Hardness of pure weld metal**

<b>as welded (HRc)</b>
55 - 59

**Weld metal analysis (typical, wt. %)**

C	Si	Cr	B				
4,8	1	28	+				

**Gas types EN 439** M 13

**Current** = +

**Current intensity**

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

**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