

Standards	DIN 8555	MF6-GF-55-PR
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Characteristics CARBO F-600 is a tubular wire which gives a CrSiC- alloyed deposit for semi automatic and automatic surfacing. The weld metal is very crack resistant and extremely tolerant in this respect to poor preheat and interpass temperature conditions. The deposit is resistant to erosion and moderate abrasion. The number of layers can be done as necessary. The deposit can be additionally treated with cutting tools.

Typical applications Parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls etc.

Mechanical properties of all-weld metal (typical values)	Hardness HRC
	approx. 56

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr
	0,5	2,7	0,5	9,5

Gas types EN 439 I1, M13: Argon and 99% Argon for 1% Oxygen

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

Coiling / Weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150/ 300 kg

Rev. 000