

## CARBO F-NiCrB 40

Standards	DIN 8555	1	MF 22-40-CG	ΓZ	
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) ca. 42				
Weld metal analysis	C Si	Cr	Ni B	Fe Ni	)
(typical, wt. %)	0,4 4,5	22 E	Base 1,7	< 5 1,	5
(typical, wt. %) Gas types EN 439			Base 1,7 gon with 1 – 5		
Gas types EN 439	I1, M13: 98	3 – 99 % Ar	gon with 1 –		1
Gas types EN 439 Current	l1, M13: 98 = +		gon with 1 – 2 ) Volt 19 - 22	2 % Oxygei Amps 120 - 220	Delivering form G
Gas types EN 439 Current	I1, M13: 98 = + DIA (mm) 1,2 1,6	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16	gon with 1 – 2 Volt 19 - 22 20 - 26	<b>2 % Oxyge</b> <b>Amps</b> 120 - 220 160 - 260	Delivering form G G
Gas types EN 439 Current	<b>I1, M13: 98</b> = + <b>DIA (mm)</b> 1,2 1,6 2,0	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16 5/64	gon with 1 – 2 Volt 19 - 22 20 - 26 22 - 27	<b>2 % Oxyge</b> <b>Amps</b> 120 - 220 160 - 260 220 - 280	n Delivering form G G G
Gas types EN 439 Current	I1, M13: 98 = + DIA (mm) 1,2 1,6 2,0 2,4	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16 5/64 3/32	gon with 1 – 2 Volt 19 - 22 20 - 26 22 - 27 24 - 28	<b>2 % Oxyge</b> <b>Amps</b> 120 - 220 160 - 260 220 - 280 260 - 340	Delivering form G G G G G
Gas types EN 439 Current	I1, M13: 98 = + DIA (mm) 1,2 1,6 2,0 2,4 2,8	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16 5/64 3/32 7/64	gon with 1 – 2 Volt 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	<b>2 % Oxygei</b> <b>Amps</b> 120 - 220 160 - 260 220 - 280 260 - 340 300 - 400	n Delivering form G G G
Gas types EN 439 Current	I1, M13: 98 = + DIA (mm) 1,2 1,6 2,0 2,4	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16 5/64 3/32	gon with 1 – 2 Volt 19 - 22 20 - 26 22 - 27 24 - 28	<b>2 % Oxygei</b> <b>Amps</b> 120 - 220 160 - 260 220 - 280 260 - 340 300 - 400	Delivering form G G G G G
Gas types EN 439 Current	I1, M13: 98 = + DIA (mm) 1,2 1,6 2,0 2,4 2,8 3,2 O = Flux co G = Flux co	<b>B – 99 % Ar</b> <b>DIA (inch)</b> 3/64 1/16 5/64 3/32 7/64 1 / 8 ored wire so	gon with 1 – 2 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30	2 % Oxyger Amps 120 - 220 160 - 260 220 - 280 260 - 340 300 - 400 320 - 460 c welding	Delivering form G G G G G G

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.