

Standards	DIN 8555	E 20-MF-40-CKTZ
------------------	----------	-----------------

Characteristics The deposit of CARBO F-S 6 L is a cobalt base alloy of austenitic-
ledeburitic structure with embedded CrW carbides.
The weld metal is highly resistant to corrosion, impact, abrasive
wear as well as thermal shocks and heavy mechanical impact.
Good aptitude for polishing and machining.

Welding instructions Lower C-content and lower hardness as CARBO F-S 6.
Working temperature should be kept between 400° and 600°C,
depending on base material and type of construction. Slow cooling,
if necessary oven cooling, is recommended for low alloyed and
austenitic steels.
Subsequent heat treatment (stress relief at 700°C approx.) is not
necessary, except on large structures.

Working temperature From room temperature up to + 600° C

Typical applications Due to its above-mentioned characteristics CARBO F-S 6 L is
particularly recommended for use on steam valves, hot shear
blades, hot pressing dies, pumps for high-temperature liquids, etc.

Mechanical properties of all-weld metal (typical values)	At Rt.	+ 300°C	+ 600°C	Melting- range °C	Density
	HRc	HRc	HRc		g/cm³
	ca. 39	ca. 32	ca. 27	1280-1390	8,3

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	W	Fe	Co	Others
	0,8	0,9	1	28	4,5	3	Base	< 3

Gas types EN 439 M13: 99% Argon with 1% Oxygen

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
	1,2	3/64	19 - 22	120 - 220	G
	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	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