

Standards	DIN 8555	MF 2 - 40
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Characteristics For low cooling the weld deposit of CARBO F-145 gives a structure similar to grey cast iron with lamellar graphite. To avoid cracks the pre-heat temperature must be 400 °C and it is necessary to hold this temperature during the whole welding process. Cooling down the work piece must be done slow as possible.
CARBO F-145 is used for repair grey cast iron and moulds.

Hardness of pure deposits	as welded (HRC)	after glowing (HB)
	40	200

Weld metal analysis (typical, wt. %)	C	Si	Mn	Fe
	2,2	3,8	0,3	Base

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 - 450	O	G
	2,8	7/64	25 - 29	300 - 500	O	G

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. 001