

Standards

DIN 8555	MF1-GF-350-P
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Characteristics CARBO F-350 is a tubular wire which produces a low alloyed hardfacing deposit of about 350 HB. The deposit is tough and not susceptible to impact loads. The number of layers can be done as necessary. The interpass temperature should be maximum 250°C.
The deposit is forgeable and can also be treated with cutting tools. In normal cases preheating is not necessary, depending on the base material. The alloy can be annealed without changing the structure of the deposits
The number of layers can be done as necessary.
The deposit can be additionally treated with cutting tools.

Typical applications Cable rolls, rails, couplings, back up rolls of caterpillars crane wheel rims, shafts, tool-joints etc.

Mechanical properties of all-weld metal (typical values)	Hardness HB
	approx. 350

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr
	0,15	0,5	2,0	2,5

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

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.