

Standards

Material No.	1.4028
EN 1600	MF 13 Mo
DIN 8555	MF 5GF-45-PR
AWS A 5.9	E 420

Characteristics

CARBO F-4028 is a tubular wire for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment.

The electrode is specially suitable for sealing surfaces on water-, steam- and gas-valves.

Recommendations for fabrication

Since ferritic steels tend to embrittlement caused by coarse grain development the heat input should be as low as possible.

For hardfacing on low alloyed base materials a preheating of 150°C-350°C subject to the thickness (on materials with higher strength 350°C) should be done.

Post weld treatment is not necessary but quench hardening to the desired hardness may be applied.

Mechanical properties of all-weld metal (typical values)

Hardness as welded
47 HRc

Weld metal analysis (typical, wt. %)

C	Cr	Mo
0,3	13,5	0,5

Gas types EN 439

I1, M13: Argon and 99% Argon with 1% Oxygen

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
1,2	3/64	19 - 23	140 - 240	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		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

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.