

Standards

DIN 8555	MF10-GF-45-CGT
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Characteristics CARBO F-42 is a tubular wire for hardfacings, resistant to wear and corrosion. The deposit is high Cr-, Ni-, Mo-, C-alloyed and is used at any place, where one can expect corrosive as well as abrasive wear. The hardfacing of welding material is possible without cracking. The alloy can be additionally worked with metalloid cutting tools.

Typical applications CARBO F-42 is normally used in the meat processing and food industry for vegetable oil extrusion presses and in the chemical industry.

Welding recommendations CARBO F-42 can be deposited crack free, but it should be preheated to a temperature depending on the base material. Controlled cooling rate is recommended. CARBO F-42 is developed for gas shielded welding with Argon (with 1-2% oxygen). The alloy is also available for submerged welding.

Mechanical properties of all-weld metal
(typical values)

Hardness HRC
approx. 43

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Ni	Mo
1,8	0,9	1,2	28,0	3,0	0,80

Gas types EN 439 M13

Current = +

Current intensity	Diameter	Volt	Ampere	Delivering form	
	1,6	20 – 26	160 – 260	G	
	2,0	22 – 27	240 – 280	G	
	2,4	24 – 28	280 – 340	G	S
	2,8	25 – 29	320 – 400		S

Delivering form

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 applicier'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 applicier to check our products for their special application autonomously.