

**Standards**

DIN 8555	MF6-GF-60-PT
----------	--------------

**Characteristics**                      CARBO F-601 is a tubular wire which gives a Cr-, Mo-, W-, V- alloyed weld deposit with excellent properties of resistance to abrasion and impact. The deposit has a high hot hardness up to 550°C. Deposits can be heat treated to increase the hardness. For use on hammer and blooming table rolls, blow bars and bucket teeth.  
The weld metal is very crack resistant and extremely tolerant in this respect to poor preheat and interpass temperature conditions. The deposit is resistant to erosion and moderate abrasion.  
The number of layers can be done as necessary.  
The deposit can be additionally treated with cutting tools.

**Typical applications**                      screws, crusher hammers, drive tumblers

**Mechanical properties of all-weld metal**  
(typical values)                      

Hardness HRC
55-58

**Weld metal analysis**  
(typical, wt. %)                      

C	Si	Mn	Cr	Mo	V	W
0,5	1,0	3,0	6,0	1,6	1,5	1,0

**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.