

Standards DIN 8555 MF 20-MF-300-CKTZ

Characteristics CARBO F-S 25 deposits a cobalt-based alloy with an austenitic structure. This alloy contains approximately 10 % nickel for matrix stability during elevated temperature service. It is resistant to hot corrosion, impact, wear and extreme temperature shocks and oxidation. The alloy is machinable by hard faced tools. CARBO F-S 25 is used for gas turbine components, on steam and chemical valves and on equipment handling hot steel, such as tong bits, shear blades, pumps for high temperature liquids. It is suitable for use at temperatures up to 900 °C.

Typical applications Hot forging tools, aerospace industry, turbo charger buckets, parts subject to high operating temperatures in combination with all types of wear such as impact, pressure, corrosion, erosion.

Working temperature From room temperature up to + 300° C

At Rt. HB	+ 900°C HB	work hardened HRC	Melting- point	Density g/cm ³
ca. 285	ca. 140	45	1300°C	8,3

C	Si	Mn	Cr	W	Ni	Co	Fe
0,1	0,9	1	20	15	10	Base	3

Gas types EN 439 **M13: 99% Argon with 1% Oxygen**

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
	1,2	3/64	19 - 22	120 - 220	G
	1,6	1/16	20 - 26	160 - 260	G
	2,0	5/64	22 - 27	220 - 280	G
	2,4	3/32	24 - 28	260 - 340	G
	2,8	7/64	25 - 29	300 - 400	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.