

Standards

DIN 8555	E 20-MF-40-CKTZ
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Characteristics The deposit of CARBO F-S 6 L is a cobalt base alloy of austenitic-
ledeburitic structure with embedded CrW carbides.
The weld metal is highly resistant to corrosion, impact, abrasive wear as well as thermal shocks and heavy mechanical impact.
Good aptitude for polishing and machining.

Welding instructions Lower C-content and lower hardness as CARBO F-S 6.
Working temperature should be kept between 400° and 600°C, depending on base material and type of construction. Slow cooling, if necessary oven cooling, is recommended for low alloyed and austenitic steels.
Subsequent heat treatment (stress relief at 700°C approx.) is not necessary, except on large structures.

Working temperature From room temperature up to + 600° C

Typical applications Due to its above-mentioned characteristics CARBO F-S 6 L is particularly recommended for use on steam valves, hot shear blades, hot pressing dies, pumps for high-temperature liquids, etc.

Mechanical properties of all-weld metal (typical values)	At Rt. HRc	+ 300°C HRc	+ 600°C HRc	Melting-range °C	Density g/cm ³
	ca. 39	ca. 32	ca. 27	1280-1390	8,3

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	W	Fe	Co	Others
	0,8	0,9	1	28	4,5	3	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