

CARBO F- 60

Standards	DIN 8555	M	-10-GF-60-C	3			
Characteristics	High C-, Cr-, Nb-alloyed flux-cored wire electrode for high abrasive wear. The weld deposit consists of chrome- and niobium-carbides. Weld metal is not machinable. Maximum deposit should be limited to three layers. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.						
Typical applications	Steel, coa	l, cement and	I mineral ind	ustry			
Mechanical propertie of all-weld metal (typical values)	es Hardne						
Weld metal analysis (typical, wt. %)	C S 5,4 1, ⁻		l b ,0				
Gas types EN 439							
Gas types EN 439 Current	 = +						
	DIA (mm)	DIA (inch)	Volt	Amps	Deliv	vering f	orm
Current	-	DIA (inch) 3/64 1/16 5/64 3/32 7/64 1 / 8	Volt 19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30	120 - 220 160 - 260 220 - 280 260 - 340	Deliv O O O O O	rering f G G G	orm S S
Current	DIA (mm) 1,2 1,6 2,0 2,4 2,8 3,2 O = Flux co G = Flux co	3/64 1/16 5/64 3/32 7/64	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29 26 - 30 • shielding shielded ar	120 - 220 160 - 260 220 - 280 260 - 340 300 - 400 320 - 460 c welding	0 0 0 0	G G	S

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.