

Standards

DIN 8555	MF6-GF-60-PT
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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