CARBO F- 61

Standards	DIN 8555	MF10-GF-65-G

Characteristics

High C-, Cr-, Nb-, B- alloyed flux-cored wire electrode with special carbides in extreme hardness. This combination results in high abrasion resistance. Applications are found in the hardfacing of mining equipment, augers, impellers and dredgers.
Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications

Steel, coal, cement and mineral industry, fan blades, excavator scoops, bucket teeth and lips

Mechanical properties of all-weld metal
(typical values)

Hardness HRC
approx. 63

Weld metal analysis
(typical, wt. %)

C	Si	Cr	Nb	B
5,4	1,1	22,0	7,0	+

Gas types EN 439 ---

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form		
1,2	3/64	19 - 22	120 - 220			
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