

CARBO F- 61

Standards	DIN 8555	MF10-GF-65-0	6	
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 propertie	s Hardness HRC			
of all-weld metal (typical values)	approx. 63			
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Weld metal analysis (typical, wt. %)	C Si Cr 5,4 1,1 22,0	Nb B 7,0 +		
Gas types EN 439				
Current	= +			
Current intensity	DIA (mm) DIA (in		Amps	Delivering form
	1,2 3/64		120 - 220	• •
	1,6 1/16 2,0 5/64		160 - 260 220 - 280	0 G 0 G
	2,0 5/64 2,4 3/32		220 - 280 260 - 340	0 G
	2,8 7/64		300 - 400	0 S
	3,2 1/8	26 - 30	320 - 460	0 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 pa	ick = 150 / 300 kg

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.