CARBO F- 868

Standards	DIN 8555	MF6-GF-55-PT

Characteristics

CARBO F-868 is a flux cored wire electrode, which produces a heat and thermal shock resistant deposit.
The electrode is designed for maintenance of hot working tools and to increase their service life.

Procedure

The number of layers can be done as necessary. The interpass temperature should be maximum 250°C.
Preheating should be chosen according to the base material.

Typical applications

Impactor dies, (screw) press dies, hot forging dies, blanking dies, etc.

Mechanical properties of all-weld metal (typical values)

Hardness HRc	Tensile strength R_m N/mm²
52-54	1800-2000

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	W	V	Ti
0,32	0,7	0,6	5,7	0,5	3	3	0,7	0,3

Gas types EN 439 I1, M 12, M13:

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	**G**
2,0	5/64	22 - 27	220 - 280	
2,4	3/32	24 - 28	260 - 340	
2,8	7/64	25 - 29	300 - 400	**G**
3,2	1 / 8	26 - 30	320 - 460	

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. 001/12