

CARBO F- 55

Standards	DIN 8	555		MF 10)-60-GR			
Characteristics	CARBO F- 55 is a tubular wire which deposits a high Cr-, C- alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever high abrasion is expected. Best results are achieved by welding in two layers. A maximum deposit thickness of 10 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.							
Typical applications	Pumps, mixer parts, conveyer screws							
Working temperature								
Hardness of pure weld metal	as welded (HRc)							
	55 - 59							
Weld metal analysis	C	Si	Cr	В				
(typical, wt. %)	4,8	1	28	+				

Gas types EN 439 M 13

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form		
	1,2	3/64	19 - 22	120 - 220	0	G	
	1,6	1/16	20 - 26	160 - 260	Ο	G	
	2,0	5/64	22 - 27	220 - 280	Ο	G	
	2,4	3/32	24 - 28	260 - 340	Ο	G	
	2,8	7/64	25 - 29	300 - 400	Ο		S
	3,2	1/8	26 - 30	320 - 460	Ο		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

Coils, weight	B/BS 300 = 15 kg	B 450 = 30 kg	pay off pack = 150 / 300 kg
Rev. 000	_	_	

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.