

<b>Standards</b>	DIN 8555	MF6-GF-70-GT																					
<b>Characteristics</b>	<p>CARBO F-725 is a metal cored wire which gives a deposit containing a high volume of extremely hard borium carbides. For parts that are exposed to high abrasive wear and erosion at temperatures up to 750°C. Lowest possible heat input gives best results.</p>																						
<b>Welding Instructions</b>	<p>Remove old deposits before overlaying, a buffer layer with CARBO F-200 or F-250 is recommended</p>																						
<b>Typical applications</b>	<p>Exhaust fans, furnace chutes, cyclones, paddles, mixer blades, transport and press screws, conveyors in the mining-, cement-, steel industries, waste recycling, power generation, petrochemical,</p>																						
<b>Hardness</b> (typical values)	<table border="1"> <thead> <tr> <th>1.layer HRC</th> <th>2.layer HRC</th> </tr> </thead> <tbody> <tr> <td>66 - 68</td> <td>67 - 71</td> </tr> </tbody> </table>	1.layer HRC	2.layer HRC	66 - 68	67 - 71																		
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<b>Weld metal analysis</b> (typical, wt. %)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Cr</th> <th>Mo</th> <th>Nb</th> <th>W</th> <th>B</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>1,3</td> <td>0,7</td> <td>17</td> <td>3</td> <td>5,8</td> <td>5,6</td> <td>4</td> <td>balance</td> </tr> </tbody> </table>							C	Si	Cr	Mo	Nb	W	B	Fe	1,3	0,7	17	3	5,8	5,6	4	balance
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<b>Gas types EN 439</b>	<p><b>M12</b> Argon with 2,5% CO<sub>2</sub>,    <b>M21</b> Argon with 10% or 18 % CO<sub>2</sub></p>																						
<b>Current</b>	<p>= +</p>																						
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<b>Delivering form</b>	<p><b>O = Flux cored wire self shielding</b>  <b>G = Flux cored wire for shielded arc welding</b>  <b>S = Flux cored wire for submerged arc welding</b></p>																						
<b>Coiling / Weight</b>	<p>B/BS 300 = 15 kg      B 450 = 30 kg      Pay off pack = 150/ 300 kg</p>																						

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