

Standards DIN 8555 MF 10-60-GR

Characteristics CARBO F- 59 is a tubular wire which deposits a high chrome carbide alloyed weld metal with excellent resistance to abrasion and moderate 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, impeller screws, track hoppers

Hardness of pure weld metal

as welded (HRc)
59 - 60

Weld metal analysis
(typical, wt. %)

C	Si	Cr	B
5,0	1,2	32	+

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		
	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

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

Rev. 000