

Standards

DIN 8555	Special alloy
DIN EN 14700	Z T Fe 8-60-GP

Characteristics

CARBO F-760 is a metal/flux cored wire for hard facing. The deposits are crack resistant and resistant against a combination of abrasion and wear due to applied impact stress. The micro structure of the deposit is a martensitic matrix of tool steel with inserted Niobium – carbides.

Due to the base material preheating temperature should be 250°C – 300°C.

Typical applications

cement crusher rolls, pulveriser rolls and hammers

Mechanical properties of all-weld metal (typical values)

Hardness HRC
55-57

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo	Nb	V	W
1,4	0,8	1	7	0,8	8	1	1,2

Gas types EN 439

M 21

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form		
1,2	3/64	20 - 23	120 - 220	G		
1,6	1/16	20 - 26	160 - 260	O	G	
2,0	5/64	24 - 27	220 - 280	O	G	
2,4	3/32	25 - 27	260 - 340	O	G	S
2,8	7/64	25 - 29	300 - 400	O		S
3,2	1/ 8	26 - 30	320 - 460			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 pack = 150/ 300 kg

Rev. 000