

# CARBO F-520

<b>Standards</b>	DIN 8555	MF23-GF-350-CKPTZ
------------------	----------	-------------------

**Characteristics** CARBO F-520 is a Cr-, Co-, Mo-, Ti-, Al- and W-alloyed flux cored wire, nickel based, for gas shielded welding with argon. The weld deposit creates regarding the Ni<sub>3</sub>Ti and Ni<sub>3</sub>Al-phases an alloy which offers a combination of good workability, formability and corrosion resistance as well as exceptional property values in the field of high temperature and high resistance against thermo shock and material fatigue

**Typical applications** Highly heat-resistant deposition on parts which are put out heavy impacts, hard facing of hammer saddle or forging saddle, steel dies, piercer etc.

**Welding Recommendation** To obtain a crack-free weld, the base material should be preheated to 350°C and held. After the welding is completed, the cooling rate should be slow.

<b>Mechanical properties of all-weld metal</b>  (typical values)	<b>Hardness HB</b>	<b>Hardness after strain-Hardening HRC</b>
	approx. 330	approx. 40

<b>Schweißgutanalyse %</b> ( Richtwert )	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Co</b>	<b>V</b>	<b>W</b>	<b>Ti</b>	<b>Al</b>
	0,05	19,0	Bal.	5,0	11,0	0,3	5,0	3,0	1,7

**Gas types EN 439** I1, M13: Argon and 99% Argon for 1% Oxygen

**Current** = +

<b>Current intensity</b>	<b>Diameter</b>	<b>Volt</b>	<b>Ampere</b>	<b>Delivering form</b>
	1,6	20 – 26	160 – 260	<b>G</b>
	2,0	22 – 27	240 – 280	<b>G</b>
	2,4	24 – 28	280 – 340	<b>G</b>
	2,8	25 – 29	320 – 400	<b>G</b>

**Delivering form** **G** = Flux cored wire for shielded arc welding

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