

CARBO SK 25

Standards		DIN 855	5		E 20-UM-3		́Т7	7		
Stanualus		000	J							
Approvals										
Characteristics		CARBO SK 25 is a rutile coated electrode which is AC weldable. The deposit is a cobalt base alloy with about 10 % Ni for matrix stability during elevated temperature service. The weld metal is highly resistant to hot corrosion, impact wear and extreme temperature shocks and oxida- tion. The alloy is machinable by hard faced tools. Hot forging tools, aerospace industry, turbo charger buckets, parts subject to high operation temperatures in combination with all types of wear such as impact, pressure, corrosion, erosion etc. The alloy is used on gas turbine components, on steam and chemical valves, on equipments handling hot steel such as tong bits, share blades, pumps for high temperature liquids.								
Operating ten	nperature	Room te	emperat	ure up to	o 900 °C					
Welding recommendat	tion	Preheating temperature should be chosen depending on base material and construction. For low alloyed steels and austenitic material a slow cooling rate is advisable.								
Mechanical properties of all-weld metal		_		D 14				Tensile strength N/mm ² 20°C 800°C		
•			-	Density g/cm ³					treng	
	etal		ge	Density g/cm ³ 8,3					treng	
of all-weld me (typical values Hardness of a metal	etal 5) all-weld	rang 1280-13 At Rt. HB	ge 390°C +	g/cm ³ 8,3 900°C HB	20°C 5,5 work har HR	80 dened	00°C 13	20°C	treng	800°C
of all-weld me (typical values Hardness of a	etal 5) all-weld	rang 1280-13 At Rt.	ge 390°C +	g/cm ³ 8,3 900°C	20°C 5,5 work har	80 dened	00°C 13	20°C	treng	800°C
of all-weld me (typical values Hardness of a metal	etal 5) all-weld 5)	rang 1280-13 At Rt. HB	ge 390°C +	g/cm ³ 8,3 900°C HB	20°C 5,5 work har HR	80 dened	00°C 13	20°C	Fe	800°C 300
of all-weld me (typical values Hardness of a metal (typical values	etal 5) all-weld 5) nalysis	rang 1280-13 At Rt. HB ca. 285	ge 390°C + 5 ca	g/cm³ 8,3 900°C HB a. 140	20°C 5,5 work har HRe ca. 4	80 dened 5	00°C 13	20°C 630		800°C 300
of all-weld me (typical values Hardness of a metal (typical values Weld metal ar	etal 5) all-weld 5) nalysis	rang 1280-13 At Rt. HB ca. 285 C	ge 390°C + 5 ca Si 0,8	g/cm ³ 8,3 900°C HB a. 140 Mn	20°C 5,5 work har HRe ca. 4	8 dened 5 5 Ni	00°C 13	20°C 630	Fe	800°C 300
of all-weld me (typical values Hardness of a metal (typical values Weld metal ar (typical, wt. %)	etal 3) all-weld 3) nalysis	rang 1280-13 At Rt. HB ca. 285 C < 0,1	ge 390°C + 5 ca 5 ca 5 ca 5 ca 0,8 −2 V	g/cm ³ 8,3 900°C HB a. 140 Mn	20°C 5,5 work har HRe ca. 4	8 dened 5 5 Ni	00°C 13	20°C 630	Fe	800°C 300
of all-weld me (typical values Hardness of a metal (typical values Weld metal ar (typical, wt. %) Current	etal 3) all-weld 3) nalysis	rang 1280-13 At Rt. HB ca. 285 C < 0,1 = + / ~ 4 PA, PB,	ge 390°C + 5 ca 5 ca 5 ca 0,8 -2 V PC	g/cm ³ 8,3 900°C HB a. 140 Mn 1	20°C 5,5 work har HRe ca. 4	8 dened 5 5 Ni	00°C 13	20°C 630	Fe	800°C 300
of all-weld me (typical values Hardness of a metal (typical values Weld metal ar (typical, wt. %) Current Welding posi	etal 3) all-weld 5) nalysis	rang 1280-13 At Rt. HB ca. 285 C < 0,1 = + / ~ 4 PA, PB,	ge 390°C + 5 ca 5 ca 5 ca 0,8 2 V PC + / - 10	g/cm ³ 8,3 900°C HB a. 140 Mn 1	20°C 5,5 work har HR ca. 4 Cr 20	8 dened 5 5 Ni	00°C 13	20°C 630	Fe	800°C 300
of all-weld me (typical values Hardness of a metal (typical values Weld metal ar (typical, wt. %) Current Welding posi Rebaking Flux-cored wi	etal 3) all-weld 5) nalysis	rang 1280-13 At Rt. HB ca. 285 ca. 285 c 0,1 = + / ~ 4 PA, PB, 1 h, 350 CARBO	ge 390°C + 5 ca 5 ca 5 ca 0,8 2 V PC + / - 10	g/cm ³ 8,3 900°C HB a. 140 1) °C (if re	20°C 5,5 work har HR ca. 4 Cr 20	80 dened 55 <u>Ni</u> 10	00°C 13	20°C 630	 < 3	800°C 300

Dia./Length	Amperage (A)	PCS./packet	PCS./Carton	Kg/ 1000	ку/раскег	kg/carton
3,2 x 350	70 - 110	140	560	35,7	5,0	20,0
4,0 x 350	100 - 140	103	412	48,6	5,0	20,0
5,0 x 350	140 - 180	64	254	78,7	5,0	20,0
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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.