

Standards	DIN 8555	MF1-GF-400-P
------------------	----------	--------------

Characteristics CARBO F-400 is a tubular wire which produces a low alloyed hardfacing deposit of about 400 HB. The deposit is tough and not susceptible to impact loads. The number of layers can be done as necessary. The interpass temperature should be maximum 250°C. The deposit is forgeable and can later be treated with cutting tools. In normal cases preheating is not necessary depending on base material. The alloy can be annealed without changing the structure of the deposits. The number of layers can be done as necessary.

Typical applications Cable rolls, rails, couplings, back up rolls of caterpillars crane wheel rims, shafts, tool-joints etc.

Mechanical properties of all-weld metal (typical values)	Hardness HB
	approx. 400

Weld metal analysis (typical, wt. %)	C	Si	Cr	Mo
	0,15	0,5	2,5	0,4

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

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
	1,2	3/64	19 - 22	120 - 220	O	G
	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

Coiling / Weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150/ 300 kg

Rev. 000