

CARBO F- 600

Standards	DIN 8555		MF6-GF-55-P	R			
Characteristics	CARBO F-600 is a tubular wire which gives a CrSiC- alloyed deposit for semi automatic and automatic surfacing. The weld metal is very crack resistant and extremely tolerant in this respect to poor preheat and interpass temperature conditions. The deposit is resistant to erosion and moderate abrasion. The number of layers can be done as necessary. The deposit can be additionally treated with cutting tools.						
Typical applications	Parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls etc.						
Mechanical propertie of all-weld metal (typical values)	Bes Hardnes appro						
Weld metal analysis (typical, wt. %)	0,5 2,7 0,5 9,5						
Gas types EN 439I1, M13: Argon and 99% Argon for 1% OxygenCurrent= +							
Current intensity	DIA (mm) 1,2 1,6 2,0 2,4	DIA (inc 3/64 1/16 5/64 3/32 7/64 1 / 8	19 - 22 20 - 26 22 - 27 24 - 28 25 - 29	Amps 120 - 220 160 - 260 220 - 280 260 - 340 300 - 400 320 - 460	Deliv 0 0 0 0 0 0	vering f G G G G	form S 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) kg	

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.