

Standards

DIN 8555	MF6-GF-60-GPTZ
----------	----------------

Characteristics

CARBO F-622 is a tubular wire which gives a Cr-, Mo-, Ni-, V- alloyed weld deposit with excellent properties of resistance to abrasion, impact and corrosion , also at higher temperatures .For base materials that are difficult to weld, a buffer layer of Carbo F-250 or preheating (300-420°C) is recommended.

Typical applications

Blooming and slabbing mill rolls

Mechanical properties of all-weld metal
(typical values)

Hardness HRC
55-58

Weld metal analysis
(typical, wt. %)

C	Cr	Ni	Mo	Nb
0,65	5,0	0,6	1,0	3,3

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	G	
1,6	1/16	20 - 26	160 - 260	G	
2,0	5/64	22 - 27	220 - 280	G	
2,4	3/32	24 - 28	260 - 340	G	S
2,8	7/64	25 - 29	300 - 400		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