

Standards

DIN 8555	MF3-GF-50-CKTZ
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Characteristics

CARBO F-495 is a tubular wire which gives a rust free weld deposit on Fe, Cr, Co, Mo-basis. This alloy has a high hot wear resistance, tensile strength and a high resistance against sliding wear of metallic objects.

It has a good retention of hardness up to 650° C and is non scaling up to 900° C, thermo shock resistant and resistant to sudden changes of temperature. Work hardening. Not crack sensible.

The number of layers can be done as necessary.

The deposit can be additionally treated with cutting tools.

Typical applications

Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls.

Hardness HRc as welded
(typical values)

untreated	work hardened
50	53

Hardness HRc Drawn for 2 h at
(typical values)

480° C	600° C	700° C	760° C
51	53	48	40

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	Co
0,2	0,7	1,2	14,5	1,5	3	12,5

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
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