

**Standards**                      DIN 8555                      MF1-GF-40-P

**Characteristics**                      CARBO F-354 is a tubular wire which produces a machinable, tough high density deposit of about 400 HB.  
The deposits are resistant to thermal shock and wear

**Typical applications**                      Repair of hammer dies, insert dies, press forging dies, where machinable deposits are required.

**Procedure**                      The number of layers can be done as necessary. The interpass temperature should be maximum 250°C.  
In normal cases preheating is not necessary but should be chosen according to the base material.

**Hardness as welded**  
(typical values)

HRc
38 - 40

**Weld metal analysis**  
(typical, wt. %)

C	Si	Mn	Cr	Mo	W	V
0,1	0,5	1	4,5	1,5	2	0,25

**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		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  
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