

CARBO F-S 6



DIN EN 14700

T Co 2-40-CKTZ

ASME IIC SFA 5.21 / AWS A 5.21 R CoCr-A

General characteristics

The deposit of CARBO F-S 6 is a cobalt base alloy of austenitic-ledeburitic structure with embedded CrW carbides. The weld metal is highly resistant to corrosion, impact, abrasive wear as well as thermal shocks and heavy mechanical impact. Good aptitude for polishing and machining.

Working temperature from room temperature up to +600°C

Typical applications

Due to its above-mentioned characteristics CARBO F-S 6 is particularly recommended for use on steam valves, hot shear blades, hot pressing dies, pumps for high-temperature liquids, etc.

Weld metal analysis (typical, wt %)

	C	Si	Mn	Cr	Co	W	Fe			
Gew-%	1,1	1,0	0,6	28,0	Basis	4,5	< 5,0			

Mechanical properties of all-weld metal (typical values)

Meltingrange:	1350°C	Hardness at Rt.	ca. 42 HRc
Density g/cm ³ :	8,3	Hardness at +300°C	ca. 35 HRc
		Hardness at +600°C	ca. 29 HRc

Operating data

Current: =+

Gas typs EN ISO 14175: M13: 99% Argon with 1% Oxygen

Dia (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	16 - 23	80 - 220	G *
1,6	1/16	18 - 27	100 - 260	G *
2,0	4/64	19 - 28	120 - 320	G *
2,4	3/32	19 - 29	160 - 380	G *
2,8	7/64	20 - 30	180 - 400	S *

Delivering form

O * = gasless (open arc), G * = gas shielded, S * = Submerged Arc

Coil "BS 300" = 15 kg

Coil "BS 450" = 25 kg

Drums = 300 kg