

# CARBO F-200

## Standards

Material No.	1.4370
DIN 8555	MF8-GF-200-CKNPZ

## Characteristics

The austenitic weld deposit of the high-alloyed flux-cored wire electrode is corrosion resistant, self hardening, anti-magnetic and heat and thermal shock resistant up to 850°C. Depending on the high elongation ( 40 % ) the alloy is suitable for ductile buffer layers on old hardfacings and joining dissimilar and difficult weldable steels.

**Typical applications** Joining of Mn – Steel and difficult weldable steels, buffer layers,

## Mechanical properties of all-weld metal (typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact energy ISO – V J at Rt.
600	>400	> 32	> 32

## Hardness HB

Hardness HB as welded	Hardness after strain-hardening
180 HB	Approx. 340 HB

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

C	Si	Mn	Cr	Ni
0,06	0,4	6,5	19	8,5

**Gas types EN 439** I1, M13: Argon and 99% Argon for 1% Oxygen

**Current** = +

## Current intensity

Diameter			Delivering form	
	Volt	Ampere		
1,6	20 – 26	160 – 260	O	G
2,0	22 – 27	240 – 280	O	G
2,4	24 – 28	280 – 340	O	G S
2,8	25 – 29	320 – 400	O	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

## Coils, weight

B/BS 300 = 15 kg    B 450 = 30 kg    pay off pack = 150/300 kg

Rev. 001/12

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.