

## CARBO F- 64

Standards	DIN 855	5	Ν	/IF10-0	GF-65-0	GZ				
Characteristics	DIN 8555MF10-GF-65-GZC-, Cr-, B-, W-, V-alloyed flux-cored wire that deposits a very hard martensitic micro structure with carbides. The deposit is resistant against strong mineral abrasion at higher temperatures. The hardness decreases about 15 % at 400°C, about 25% at 600°C.Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits cannot be heat-treated, machined or forged.Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.									
Typical applications	mineral a	and brick	indust	try, im	oeller ,	mixe	r parts, s	scraper	S	
Mechanical properties	Hard HF	H	Hardness HRC at 400° C				Hardness HRC at 600° C			
of all-weld metal (typical values)	approx. 63			approx. 53			approx. 47			
		-	-		Б					
Wold motal analysis	C			<b>\</b> \/						
Weld metal analysis (typical, wt. %)	<b>C</b> 3,8		<b>V</b> ,8	<b>W</b> 0,8	<b>B</b> 1,0					
-										
(typical, wt. %)										
(typical, wt. %) Gas types EN 439	3,8	22 0		0,8		Α	mps	Deliv	vering form	
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2	22 0	,8 ( <b>inch)</b> 64	0,8 <b>V</b> 19	1,0 /olt - 22	120	) - 220	Deliv	vering form	
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2 1,6	22 0 n) <b>DIA</b> 3/ 1/	,8 ( <b>inch)</b> 64 16	0,8 <b>V</b> 19 20	1,0 /olt - 22 - 26	120 160	) - 220 ) - 260	0	vering form	
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2 1,6 2,0	22 0 n) <b>DIA</b> 3/ 1/ 5/	,8 ( <b>inch)</b> 64 (16) 64	0,8 <b>V</b> 19 20 22	1,0 /olt - 22 - 26 - 27	120 160 220	) - 220 ) - 260 ) - 280	0 0	vering form	
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2 1,6 2,0 2,4	22 0 n) DIA ( 3/ 1/ 5/ 3/	,8 ( <b>inch)</b> 64 (16 (64 (32)	0,8 19 20 22 24	1,0 /olt - 22 - 26 - 27 - 28	120 160 220 260	) - 220 ) - 260 ) - 280 ) - 340	0 0 0		
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2 1,6 2,0	22 0 n) DIA 3/ 1/ 5/ 3/ 7/	,8 ( <b>inch)</b> 64 (16) 64	0,8 19 20 22 24 25	1,0 /olt - 22 - 26 - 27	120 160 220 260 300	) - 220 ) - 260 ) - 280	0 0	vering form S S	
(typical, wt. %) Gas types EN 439 Current	3,8  = + DIA (mn 1,2 1,6 2,0 2,4 2,8	22 0 n) DIA 3/ 1/ 5/ 3/ 7/ 1 cored w cored w	,8 (inch) 64 16 64 32 64 78 ire se ire fo	0,8 19 20 22 24 25 26 elf shie	7 olt - 22 - 26 - 27 - 28 - 29 - 30 elding ded ar	120 160 220 260 300 320	) - 220 ) - 260 ) - 280 ) - 340 ) - 340 ) - 400 ) - 460 Iding	0 0 0 0	S	

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.