

**Standards**

DIN 8555	MF 21-GF-65-GZ
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**Characteristics** CARBO F- DURIT is a tubular wire containing fused tungsten carbides for extreme wear resistant hardfacings. The weld metal is composed of fused tungsten carbides which are embedded in a hard matrix alloy.  
CARBO F- DURIT is easy to use and has little spatter and smoke. It should be welded in max. 2 layers using lowest possible Amp and Volts.

**Typical applications** Hardfacing equipment parts which are subject to strong abrasive wear with little impact.  
On parts such as mixer blades, moulding sand preparation plants, augers, scrapers etc.

**Recommendations for best welding results** Thoroughly clean the welding zone. It should be exempt from grease, scale, corrosion, and similar contamination.  
Preheat the work piece to 300 - 500° C. During the welding process the local base material temperature has to be increased to 650°C, however, overheating should be avoided.

**Hardness** ( typical values )

Fused tungsten carbide HV	1.layer HRc	2.layer HRc
> 2300	64	66

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

Fe - Matrix	WSC
40	60

**Gas types EN 439** M13: 99% Argon with 1% Oxygen

**Current** = +

**Current intensity**

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 160	G
1,6	1/16	18 - 20	150 - 180	G
2,0	5/64	21 - 23	200 - 230	G
2,4	3/32	21 - 23	220 - 260	G
2,8	7/64	23 - 25	240 - 280	G

**Delivering form**  
O = Flux cored wire self shielding  
G = Flux cored wire for shielded arc welding

**Coils, weight** B/BS 300 = 15 kg      B 450 = 30 kg  
Rev. 000

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.