

Standards

DIN 8555	MF 5-40-CPT
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Characteristics CARBO F-356 N is a corrosion resistant CrNiMo-alloyed, flux-cored wire. The deposit has a moderate hardness, is tough and not susceptible to impact loads and pressure
The wire is especially suited for a two layer plating on forged rollers for continuous casters. The high alloy rate of the deposit gives already favorable conditions in the first layer, which means that even after mechanical treatment the mixing area contains enough of the important components Cr, Mo and Ni. The deposit is forgeable and can also be treated with cutting tools.

Typical applications forged rollers for continuous casters

Mechanical properties of all-weld metal (typical values)

Hardness HRC
42 -45

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	Mn	Nb	N	Ti +Al	Fe
0,04	1,2	1,1	15	4,3	1,2	1,0	0,2	0,09	+	Base

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,6	1/16	20 - 26	160 - 260	O S
2,4	3/32	24 - 28	260 - 340	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

Coiling / Weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150/ 300 kg
Rev. 000