

Standards	DIN 8555	MF8-GF-200-CKNPZ
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Characteristics

CARBO F-305 is a rutile flux cored stainless steel wire for joining and protective coatings.
 Attractive bead appearance, very good penetration and high productivity.
 Maximum performances in the horizontal and down hand positions.
 Welded with classical economical Ar-CO₂ mixtures or CO₂.

Typical applications

Welding wrought, forged or cast stainless steels for service in the as-welded condition.
 Heterogeneous welding between stainless steels and other stainless and mild or low alloyed steels.

Hardness	HV30
	200

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	Mo	Ni
	0,1	0,8	1	20	1	10

Gas types EN 439 M21 gas mixtures (Ar + 5 – 25% CO₂) or C1 (CO₂)

Welding Positions PA, PB, PC

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
	1,6	1/16	23 - 37	150 - 400		G
	2,0	5/64	22 - 27	180 - 300	O	G
	2,4	3/32	24 - 28	200 - 350	O	G
	2,8	7/64	25 - 29	250 - 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

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