

CARBO S-1.2343

CARBO T-1.2343

International standards

	S = solid wire	T = bare rod
Mat. No.	1.2343	

Typical applications and characteristics

CARBO T+S 1.2343 for high wear resistant hardfacings on hot- and cold- working tools. The deposit has a crack-free Cr-Mn-martensitic structure.
Particularly recommended for hardfacing hot- and cold-working trimming dies, pressing- and blanking dies, hot- and cold-shear-blades like hot-billet-shears, blanking-,punching and coining tools, rotary-shear-knives, hot- and cold-forming- and drawing-dies.

Recommendations for welding and heat treatment

For achieving optimal crack-free deposits preheating of the base material to 250-350 centigrade is essential.
Short runs are desirable using the step back technique.

Base materials

1.2343	X38CrMoV5-1	1.2083	X42Cr13
1.2344	X40CrMoV5-1	1.2367	X38CrMoV5-3
1.2082	X21Cr13	1.2606	X37CrMoW5-1

Mechanical properties of all-weld metal

(typical values)

First layer HRC
52-57

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Mo	V	Fe
0,38	1,0	0,4	5,0	1,1	0,45	Base

Gas types EN 439

S = solid wire	T = bare rod
M2, M3	I1

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300	15 kg.	10 kg.
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