

# CARBO S-1.2713

# CARBO T-1.2713

## International standards

	S = solid wire	T = bare rod
Mat. No.	1.2713	

## Typical applications and characteristics

CARBO T+S 1.2713 for high wear resistant hardfacings on hot- and cold- working tools. The deposit has a crack-free Cr-Ni-Mo-Mn- martensitic structure. With low carbon content. 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

1.2713	55NiCrMoV6	1.2747	28NiMo17
1.2714	56NiCrMoV7	1.2764	X19NiCrMo4
1.2740	28NiCrMoV10	1.2766	35NiCrMo16
1.2743	60NiCrMoV12-4	1.2767	X45NiCrMo4
1.2744	57NiCrMoV7-7		

## Mechanical properties of all-weld metal

( typical values)

First layer HB
ca. 360-420 HB

## Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	V	Fe
0,25	0,30	0,5	1,45	3,60	0,40	0,2	Base

## Gas types EN 439

S = solid wire	T = bare rod
M2, C1	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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