

Standards

DIN 8555	MF6-GF-C1 60-GP
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Characteristics CARBO F-606 is a basic type tubular wire for gas shielded welding which produces a deposit of about 600 HB for semi automatic and automatic hardfacing.
The weld metal is tough, crack free and resistant to shocks, impact and moderate abrasion.
The deposits are only machinable by grinding.
Heat treatment after hardfacing will decrease as welded hardness.

Typical applications Parts subjected to abrasion, impact and compressive loads, crusher jaws, sand pumps, dredge pump parts, dredge ladder rolls etc.

Mechanical properties of all-weld metal (typical values)

Hardness HRC
57-60

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo
0,5	0,6	1,5	5,5	0,5

Gas types EN 439 CO₂ or M21 shielding gas

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 220	G
1,6	1/16	20 - 26	160 - 260	G

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
Rev. 000