

CARBO F-212

Standards	DIN 8555	MF7-GF-250-KNP
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Characteristics The metal-cored wire electrode is suitable for welding parts, which are exposed to high cavitation and corrosion. The non-magnetic austenitic deposit is tough, crack-free and work hardening. Typical applications can be found in the rebuilding of crusher jaws, railroad components, bucket teeth and lips, and it is designed for reclaiming worn parts of manganese base material.

Mechanical properties of all-weld metal
(typical values)

Hardness HB	Hardness after work hardening HB
280	450

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Co	N
0,2	2,3	9	16	8,5	0,2

Gas types EN 439 I1, M12: 100% Argon and Argon with max. 5% CO₂

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
2,0	5/64	22 - 27	220 - 280	G
2,4	3/32	24 - 28	260 - 340	G
2,8	7/64	25 - 29	300 - 400	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

Coils, 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 applicier'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 applicier to check our products for their special application autonomously.