

Standards

DIN 8555	MF 10-60-GR
----------	-------------

Characteristics CARBO F- 53 is a tubular wire which deposits a high Cr-, C- alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever abrasion is expected in combination with corrosion.
Best results are achieved by welding in two layers. A maximum deposit thickness of 10 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications Pumps, impeller screws, track hoppers mixer parts,

Working temperature

Hardness of pure weld metal

as welded (HRc)
ca. 58

Weld metal analysis (typical, wt. %)

C	Si	Cr
3,7	1,2	32

Gas types EN 439 M 13

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
1,2	3/64	19 - 22	120 - 220		
1,6	1/16	20 - 26	160 - 260	O	G
2,0	5/64	22 - 27	220 - 280	O	G
2,4	3/32	24 - 28	260 - 340	O	G
2,8	7/64	25 - 29	300 - 400	O	S
3,2	1 / 8	26 - 30	320 - 460	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

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg
Rev. 000