CARBO F- 70

Standards	DIN 8555	MF10-GF-65-G

Characteristics

High C-, Cr-, V - alloyed flux-cored wire electrode for high abrasive wear. The weld deposit consists of chrome- and vanadium-carbides. Weld metal is not machinable. Maximum deposit should be limited to three layers.
Before overlaying on old previously hard faced surfaces a buffering layer of CARBO F-200 or CARBO F-250 is recommended.

Typical applications

Steel, coal, cement and mineral industry

Mechanical properties of all-weld metal (typical values)

Hardness HRC
approx. 63

Weld metal analysis (typical, wt. %)

C	Si	Cr	V
5,3	1,1	24,5	5,5

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**

Coiling / Weight

B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000