

Standards DIN 8555 MF1-GF-55-P

Characteristics CARBO F-335 is a tubular wire which produces a carbon manganese alloyed hardfacing deposit of about 600 HB. The deposits are fine grained, tough and not susceptible to impact loads.

Procedure The number of layers can be done as necessary. The interpass temperature should be maximum 250°C.
In normal cases preheating is not necessary but should be chosen according to the base material.
The deposit is forgeable and can be heat treated according to oil hardening heat treatment procedures.

Typical applications Repair of hardening tools and dies, forming, blanking and cutting dies, shears cutting edges etc.

Hardness as welded
(typical values)

HRc
approx. 57

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Mo	Ni
0,2-0,25	0,3	1	2,2	0,7	1

Gas types EN 439 I1, M13: Argon and 99% Argon for 1% Oxygen

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
	1,2	3/64	19 - 22	120 - 220	O	G
	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		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

Statements on composition and application are just for the applier'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 applier to check our products for their special application autonomously.