

**Standards**

DIN 8555	MF5-GF-450-PRT
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**Characteristics**                      CARBO F-440 is a tubular wire which produces a weld deposit resistant to impact and medium abrasive wear, but also against corrosion and continuous rating through heat effect.

**Welding Recommendation**                      Interpass Temperature should be max. 450°C

**Typical applications**                      Hot strip mill table rolls, pinch rolls

<b>Hardness after heat treatment at</b> (typical values HB)	480 °C	510°C	540°C	570°C	600°C
	480-500	460-490	440-480	400-430	320-350

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Cr</b>	<b>Mo</b>	<b>Ni</b>	<b>V</b>
	0,25	12	1,5	2,3	1

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

**Current**                                      = +

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

**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