

# CARBODUR 600 B

**Standards**

DIN 8555	E 6- UM - 60 GP
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**Characteristics** CARBODUR 600 B is a basic coated high efficiency electrode with 130 % recovery for hardfacing by applying tough-hard and abrasion-proof layers Suitable for hardfacing on machine components made of engineering steel, cast steel and manganese steel.  
Smooth, intense fusion, fine-scaled seam, and easy slag removal.  
The pure weld deposit is only machinable by grinding.  
The electrode has a soft but intensive welding character, a fine-structured seam surface and excellent slag-removal properties.  
Suitable for hardfacing on machine components made of engineering steel, cast steel and manganese steel.  
Smooth, intense fusion, fine-scaled seam, and easy slag removal. The deposit can only be machined by grinding.

**Welding instructions** Guide electrode almost vertically with a short arc  
Highly carburized or crack-sensitive base materials should be preheated to 200° – 300° C. On highly crack-sensitive base materials and manganese steel, a buffer layer of CARBO 4370 MPR or CARBODUR MnCr is recommended.

**Typical applications** Rollers, caterpillar tracks, track wheels, running surfaces, chaser mills, cams, paving breakers, baffles, dredger parts, rolling crushers, etc.

**Operating temperature**

Hardness and recommendations for heat treatment	HRC as welded	Annealing: 5 h	Hardening oil - air
	ca. 59	780°C – 820° C	1000°C – 1050° C

Weld metal analysis (typical. wt %)	C	Cr	Mo	V
	0,6	9	0,5	1,4

**Current** = + / partly ~ / 42 V

**Welding positions** PA. PB. PC. PD. PE

**Rebaking** 1 h. 200 °C + (if required)

**Flux-cored wire equivalent**

CARBO F- 601
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Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	50 - 80	227	909	22,0	5,0	20,0
3,2 x 450	70 - 110	126	503	47,7	6,0	24,0
4,0 x 450	100 - 150	83	332	72,3	6,0	24,0
5,0 x 450	140 - 190	53	213	112,9	6,0	24,0
6,0 x 450	170 - 230	37	148	162,6	6,0	24,0

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.