

CARBO S-G 600

CARBO T-G 600

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	1.4718	
DIN 8555	MSG 6-GZ-60-S	WSG 6-GZ-60-S

Application notes

Massive wire for rebuilding of machine parts subject to combined wear from abrasion and impact. Suitable for deposits on mild steel, steel castings and manganese steel.

The pure weld deposit is only machinable by grinding.

On high-carbon and crack-sensitive base materials, should be preheated to 200° – 300° C, depending on their composition and thickness.

Typical applications

Rollers, dredger chains, conveyors, hammers, dredger equipment, mining and earth-moving equipment

Hardness of all-weld metal (typical values)

as welded	soft annealed 5 h	Hardened oil - air cooling
59 HRc	780°C – 820° C	1000°C – 1050°C

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr
0,5	3,0	0,5	9

Gas types EN 439

S = massive wire	T = bare rod
M2, M3, C1	I1

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

Rev. 000

B300 15 kg.

10 kg.