CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO S-1.2713
CARBO T-1.2713

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	1.2713	

Typical applications and characteristics

CARBO T+S 1.2713 for high wear resistant hardfacings on hot- and cold- working tools. The deposit has a crack-free Cr-Ni-Mo-Mn- martensitic structure. With low carbon content. Particularly recommended for hardfacing hot- and cold-working trimming dies, pressing- and blanking dies, hot- and cold-shear-blades like hot-billet-shears, blanking-,punching and coining tools, rotary-shear-knives, hot- and cold-forming- and drawing-dies.

Recommendations for welding and heat treatment

For achieving optimal crack-free deposits preheating of the base material to 250-350 centigrade is essential.
Short runs are desirable using the step back technique.

Base materials

1.2713	55NiCrMoV6	1.2747	28NiMo17
1.2714	56NiCrMoV7	1.2764	X19NiCrMo4
1.2740	28NiCrMoV10	1.2766	35NiCrMo16
1.2743	60NiCrMoV12-4	1.2767	X45NiCrMo4
1.2744	57NiCrMoV7-7		

Mechanical properties of all-weld metal

(**typical values**)

First layer HB
ca. 360-420 HB

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	V	Fe
0,25	0,30	0,5	1,45	3,60	0,40	0,2	Base

	S = massive wire	T = bare rod
Gas types EN 439	M2, 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 B300 15 kg. 10 kg.

Rev. 000