

Standards

DIN 8555	MF6-GF-70-GT
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Characteristics CARBO F-726 is a metal cored wire which gives a deposit containing a high volume of extremely hard borium carbides. For parts that are exposed to high abrasive wear and erosion at temperatures up to 750°C. Lowest possible heat input gives best results.

Welding Instructions Remove old deposits before overlaying, a buffer layer with CARBO F-200 or F-250 is recommended

Typical applications Exhaust fans, furnace chutes, cyclones, paddles, mixer blades, transport and press screws, conveyors in the mining-, cement-, steel industries, waste recycling, power generation, petrochemical,

Hardness
(typical values)

1.layer HRC	2.layer HRC
66 - 68	67 - 71

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	B	Fe
0,1	1,4	1,3	29	4	balance

Gas types EN 439 **M12** Argon with 2,5% CO₂, **M21** Argon with 10% or 18 % CO₂

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,6	1/16	23 - 32	160 - 300	G

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